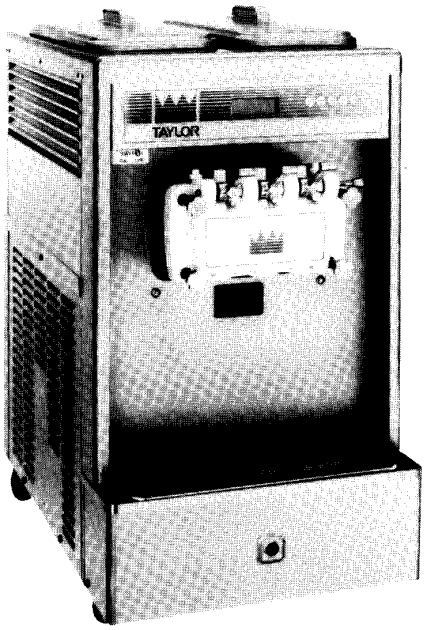
OPERATOR'S MANUAL

TAYLOR®

Freezemaster

Model 337



Twistmaster

Carrier

TAYLOR®

Complete this page for quick reference when service is required:

Taylor Distributor:_____

Address:_____

Phone:_____

Service:_____

Parts:_____

Date of Installation:_____

Information found on the data label:

Model Number:_____

Serial Number:_____

Electrical Specs: Voltage_____Cycle_____

Phase_____

Maximum Fuse Size:_____A

Minimum Wire Ampacity:_____A

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044869-M

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Taylor Company
750 N. Blackhawk Blvd.
Rockton, IL 61072

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Service to Keep You Serving . . . . . Inside Back Cover

To the Installer

This machine is designed for indoor use only.

DO NOT install the machine in an area where a water jet could be used to clean or rinse the machine. Failure to follow this instruction may result in serious electrical shock.

WATER CONNECTIONS (Water Cooled Units Only)

An adequate cold water supply must be provided with a hand shut-off valve. On the underside rear of the base pan, two 3/8" I.P.S. water connections for inlet and outlet have been provided for easy hook-up. 1/2" inside diameter water lines should be connected to the machine. (Flexible lines are recommended, if local codes permit.) Depending on local water conditions, it may be advisable to install a water strainer to prevent foreign substances from clogging the automatic water valve. There will be only one water "in" and one water "out" connection. DO NOT install a hand shut-off valve on the water "out" line! Water should always flow in this order: first, through the automatic water valve; second, through the condenser; and third, through the outlet fitting to an **open trap drain.**

AIR COOLED UNITS

Air cooled units require a minimum of 6" (152 mm) of clearance around **all** sides of the freezer to allow for adequate air flow across the condenser(s). Failure to allow adequate clearance can reduce the refrigeration capacity of the freezer and possibly cause permanent damage to the compressor.

ELECTRICAL CONNECTIONS

Each freezer requires one power supply for each data label. Check the data label on the freezer for fuse, circuit ampacity and electrical specifications. Refer to the wiring diagram provided inside of the electrical box, for proper power connections.

In the United States, this equipment is intended to be installed in accordance with the National Electrical Code (NEC), ANSI/NFPA 70-1987. The purpose of the NEC code is the practical safeguarding of persons and property from hazards arising from the use of electricity. This code contains provisions considered necessary for safety. Compliance therewith and proper maintenance will result in an installation essentially free from hazard!

In all other areas of the world, equipment should be installed in accordance with the existing local codes. Please contact your local authorities.

Stationary appliances which are not equipped with a power cord and a plug or other device to disconnect the appliance from the power source must have an all-pole disconnecting device with a contact gap of at least 3 mm installed in the external installation.

CAUTION: THIS EQUIPMENT MUST BE PROPERLY GROUNDED! FAILURE TO DO SO CAN RESULT IN SEVERE PERSONAL INJURY FROM ELECTRICAL SHOCK!

Beater rotation must be clockwise as viewed looking into the freezing cylinder.

Note: The following procedures should be performed by a trained service technician.

To correct the rotation on a three-phase unit, interchange any two incoming power supply lines at freezer main terminal block only.

To correct rotation on a single-phase unit, change the leads inside the beater motor. (Follow the diagram printed on the motor.)

Electrical connections are made directly to the terminal block. The terminal block is provided in the main control box located behind the lower front trim.

To the Operator

The freezer you have purchased has been carefully engineered and manufactured to give you dependable operation. The Taylor Model 337, when properly operated and cared for, will produce a consistent quality product. Like all mechanical products, this machine will require cleaning and maintenance. A minimum amount of care and attention is necessary if the operating procedures outlined in this manual are followed closely.

This Operator's Manual should be read before operating or performing any maintenance on your equipment.

Your Model 337 will NOT eventually compensate for and correct any errors during the set-up or filling operations. Thus, the initial assembly and priming procedures are of extreme importance. It is strongly recommended that all personnel responsible for the equipment's operation study these procedures together in order to be properly trained and to make sure that no misunderstandings exist.

If you require technical assistance, please contact your local authorized Taylor Distributor.

If the crossed out wheeled bin symbol is affixed to this product, it signifies that this product is compliant with the EU Directive as well as other similar legislation in effect after August 13, 2005. Therefore, it must be collected separately after its use is completed, and cannot be disposed as unsorted municipal waste.

The user is responsible for returning the product to the appropriate collection facility, as specified by your local code.

For additional information regarding applicable local laws, please contact the municipal facility and/or local distributor.

COMPRESSOR WARRANTY DISCLAIMER

The refrigeration compressor(s) on this machine are warranted for the term indicated on the warranty card accompanying this machine. However, due to the Montreal Protocol and the U.S. Clean Air Act Amendments of 1990, many new refrigerants are being tested and developed, thus seeking their way into the service industry. Some of these new refrigerants are being advertised as drop-in replacements for numerous applications. It should be noted that, in the event of ordinary service to this machine's refrigeration system, **only the refrigerant specified on the affixed data label should be used**. The unauthorized use of alternate refrigerants will void your compressor warranty. It will be the owner's responsibility to make this fact known to any technician he employs.

It should also be noted that Taylor does not warrant the refrigerant used in its equipment. For example, if the refrigerant is lost during the course of ordinary service to this machine, Taylor has no obligation to either supply or provide its replacement either at billable or unbillable terms. Taylor does have the obligation to recommend a suitable replacement if the original refrigerant is banned, obsoleted, or no longer available during the five year warranty of the compressor.

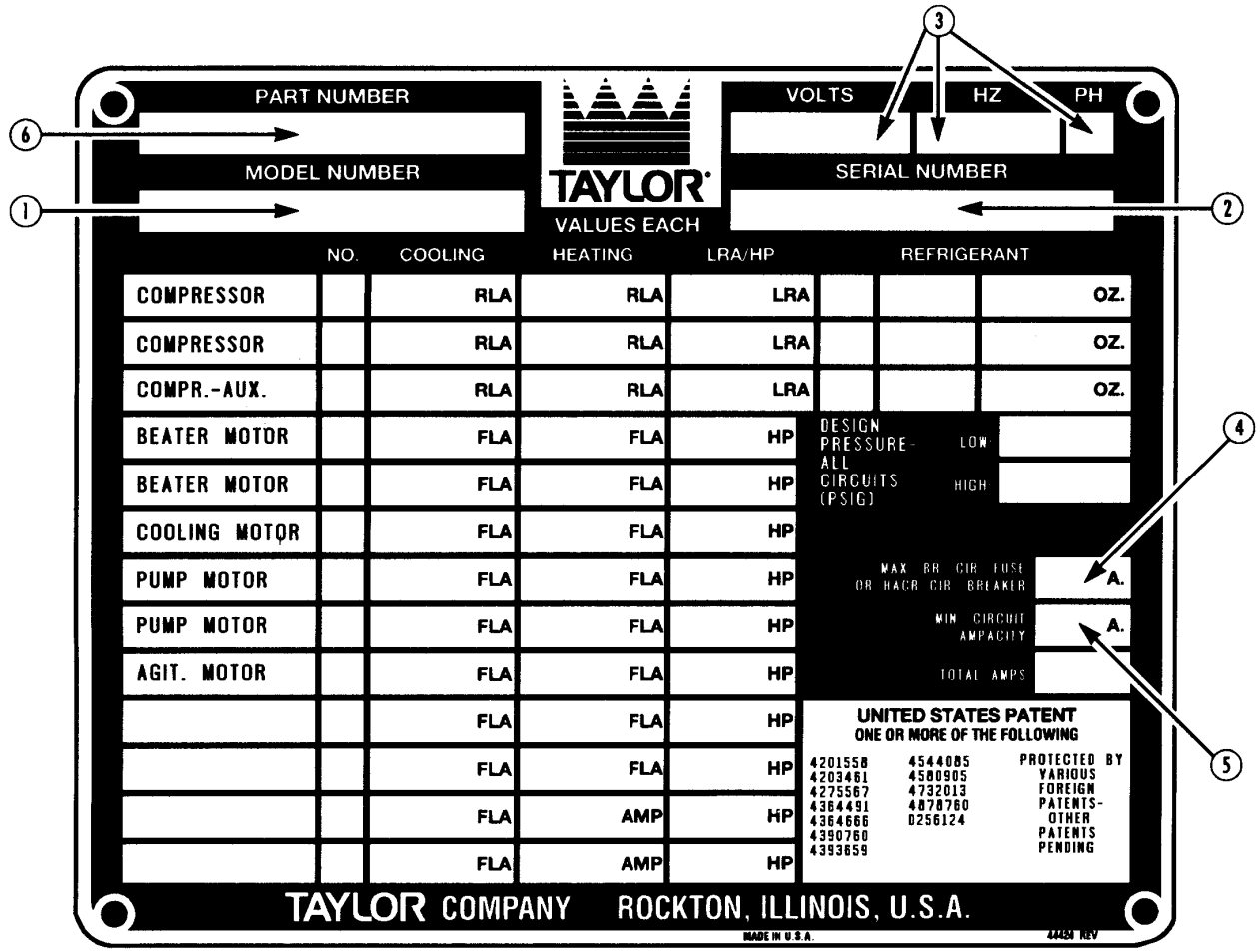
The Taylor Company will continue to monitor the industry and test new alternates as they are being developed. Should a new alternate prove, through our testing, that it would be accepted as a drop-in replacement, then the above disclaimer would become null and void. To find out the current status of an alternate refrigerant as it relates to your compressor warranty, call the local Taylor Distributor or the Taylor Factory. Be prepared to provide the Model/Serial Number of the unit in question.

Data Plate

The freezer data plate provides necessary information that the operator should record and refer to when this information is requested by:

A. Electrician
B. Service Technician
C. Parts Manager for service parts
D. Warranty status

The data plate is located on the rear panel.



Complete for quick reference when this information is requested:

1. Model Number: _____
2. Serial Number: _____
3. Electrical Specs: Voltage _____ Cycle _____
   Phase _____
4. Maximum Fuse Size: _____ Amps
5. Minimum Wire Ampacity: _____ Amps
6. Part Number: _____

Safety

We at Taylor Company are concerned about the safety of the operator when he or she comes in contact with the freezer and its parts. Taylor has gone to extreme efforts to design and manufacture built-in safety features to protect both you and the service technician. As an example, warning labels have been attached to the freezer to further point out safety precautions to the operator.

IMPORTANT - Failure to adhere to the following safety precautions may result in severe personal injury. Failure to comply with these warnings may also damage the machine and its components. Component damage will result in part replacement expense and service repair expense**.**

To Operate Safely:

DO NOT operate the freezer without reading this operator's manual. Failure to follow this instruction may result in equipment damage, poor freezer performance, health hazards, or personal injury.

- **DO NOT** operate the freezer unless it is properly grounded.
- **DO NOT** attempt any repairs unless the main power supply to the freezer has been disconnected.
- **DO NOT** operate the freezer with larger fuses than specified on the freezer data label.

Failure to follow these instructions may result in electrocution or damage to the machine. Contact your local authorized Taylor Distributor for service.

DO NOT use a water jet to clean or rinse the freezer. Failure to follow this instruction may result in serious electrical shock.

- **DO NOT** allow untrained personnel to operate this machine.
- **DO NOT** operate the freezer unless all service panels and access doors are restrained with screws.
- **DO NOT** remove the door, beater and blades, or drive shaft unless all control switches are in the OFF position.
- **DO NOT** put objects or fingers in door spout.

Failure to follow these instructions may result in contaminated product or severe personal injury to fingers or hands from hazardous moving parts.

USE EXTREME CAUTION when removing the beater assembly. The scraper blades are very sharp and may cause injury.

This freezer must be placed on a level surface. Failure to comply may result in personal injury or equipment damage.

DO NOT obstruct air intake and discharge openings:

A minimum of 6" (152 mm) air space is required on both sides and rear, and 4-1/4" (108 mm) on bottom. Failure to follow this instruction may cause poor freezer performance and damage to the machine.

This freezer is designed to operate indoors, under normal ambient temperatures of 70°-75°F (21°-24°C). The freezer has successfully performed in high ambient temperatures of 104°F (40°C) at reduced capacities.

NOISE LEVEL: Airborne noise emission does not exceed 78 dB(A) when measured at a distance of 1.0 meter from the surface of the machine and at a height of 1.6 meters from the floor.

Taylor Company® Warranty

A warranty checkout card is shipped with every new freezer that leaves the factory. The warranty checkout card is packed in an envelope which also contains this operator's manual. Refer to the warranty checkout card and the warranty classifications listed in the parts list at the back of this manual when service is performed on your freezer.

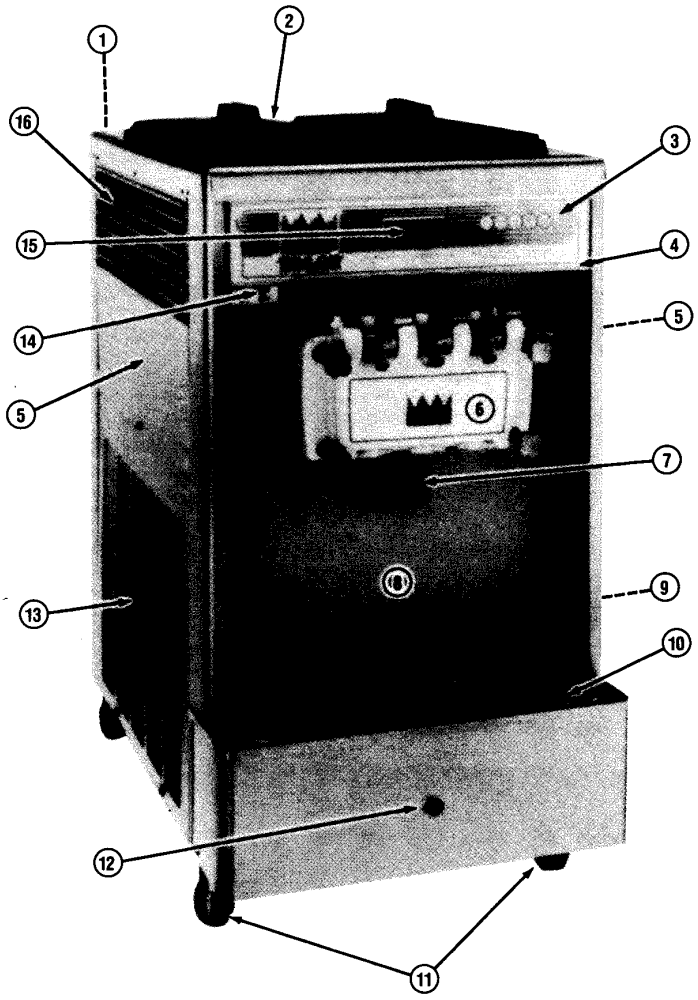
It is strongly recommended that the operator take the necessary time to carefully read through the complete warranty information contained in the warranty checkout card. Any questions or unclear statements found within the card should be made clear to you upon delivery of the freezer. Thoroughly understand your warranty protection before you begin operation.

Taylor Company stands behind the quality of design and manufacturing that is put into every model we make...more so than anyone else in the industry. The Taylor Company Warranty is a strong example of this and exemplifies how important we feel it is to keep you a satisfied and proud owner of a Taylor freezer.

For any questions pertaining to the Taylor Warranty, please contact your authorized Taylor Distributor or Taylor Company, Rockton, Illinois 61072.

Controls and Panels

Model 337

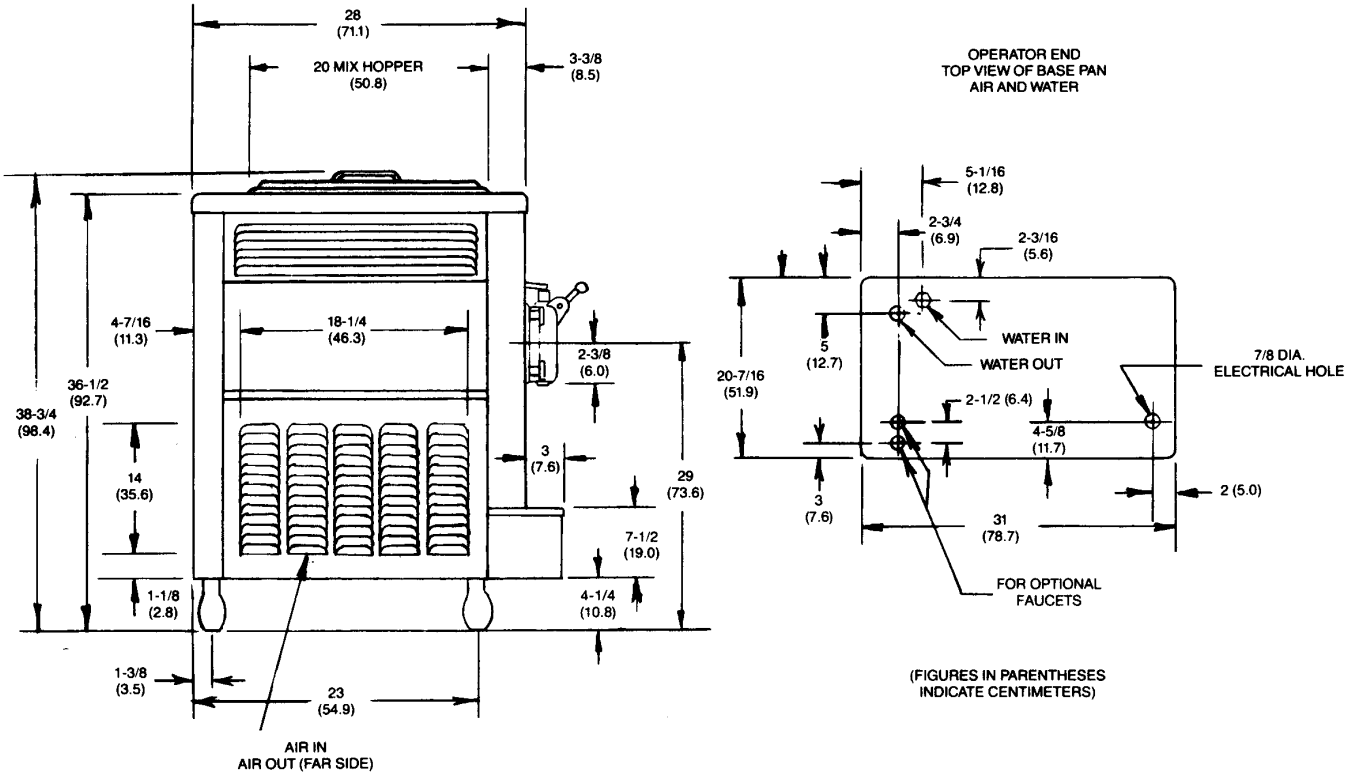


Item	Description	Part No.
1.	Rear Panel	044287
2.	Mix Hopper Cover	041682-GRY
3.	Taylor Decorative Decal	044214
4.	Decorative Plate Assembly*	X44276
5.	Upper Side Panel	024426
6.	Freezer Door Assembly	X45378-SER
7.	Rear Drip Pan	027504
8.	Front Panel Assembly	X44247
9.	Right Side Panel Assembly	X44278
10.	Splash Shield	022765
11.	Leg	013458
12.	Reset Button (Beater Line Starter)*	041950-27K
13.	Left Side Panel Assembly	X45082
14.	Power Toggle Switch*	024295
15.	Liquid Crystal Display*	X38062-SER
16.	Side Louver	017471

*See page 13 for more detailed information.

Specifications

Model 337



(Figures in parentheses indicate centimeters.)

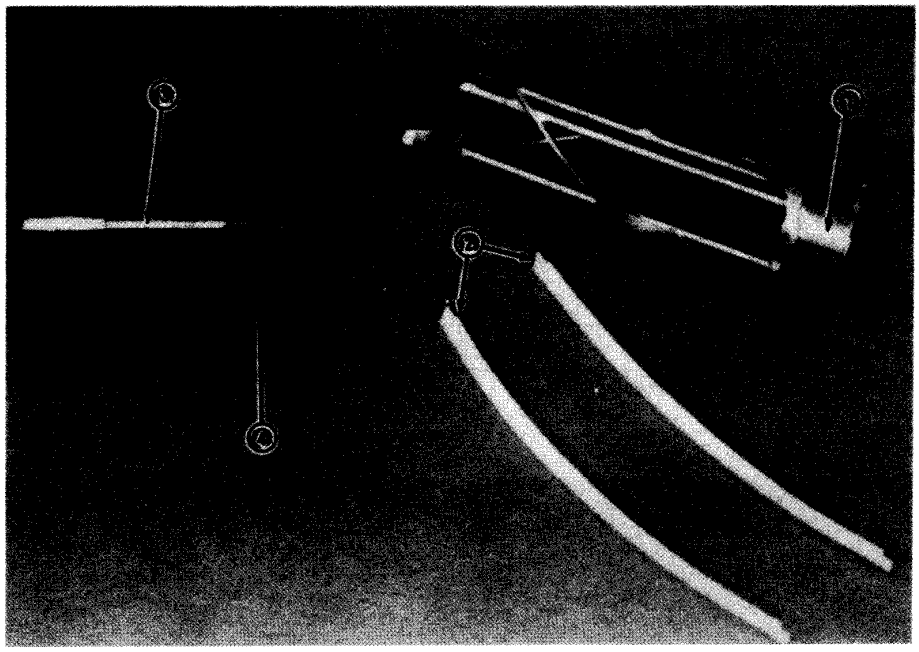
- **FREEZING CYLINDER.** Two; 2.8 quart (2.7 liter) capacity.
- **MIX HOPPER.** Two; 14 quart (13.2 liter) capacity. Refrigerated and insulated.
- **BEATER MOTOR.** One; 1.5 hp.
- **REFRIGERATION UNIT.** One; approximately 9,500 btu/hr compressor. Refrigerant 502.
- **ELECTRICAL.** Standard is 208/230-60-1 or 208/230-60-3; however, other electrical characteristics are available. Each unit requires electrical service* — Single Phase Maximum Fuse Size: 35 Amps. Minimum Wire Ampacity: 25A. Three Phase Maximum Fuse Size: 20 Amps. Minimum Wire Ampacity: 17A.
- **AIR COOLED.** Clearance: 6″ (15.2 cm) around all sides, 4-1/4″ (10.8 cm) on bottom.
- **WATER COOLED.** Water inlet and drain connections under side of base 3/8″ FPT.
- **DIMENSIONS.** Width: 20-7/16″ (51.9 cm). Depth: 31″ (78.7 cm). Height: 38-3/4″ (98.4 cm). Counter Clearance: 4-1/4″ (10.8 cm) mounted on standard legs.
- **APPROXIMATE WEIGHTS.** Net: 450 lbs. (204.1 kgs.). Crated: 506 lbs. (229.5 kgs.), 29.1 cu. ft. (.81 cu. m.).

***For exact electrical information, always refer to the data plate of the unit.**

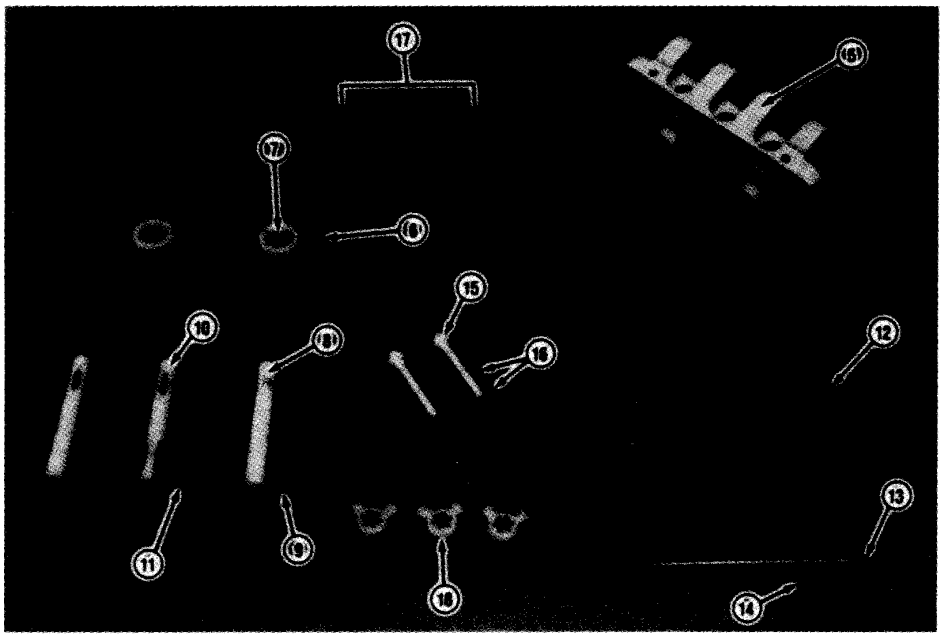
Availability and specifications subject to change without notice.

Operator Parts Identification

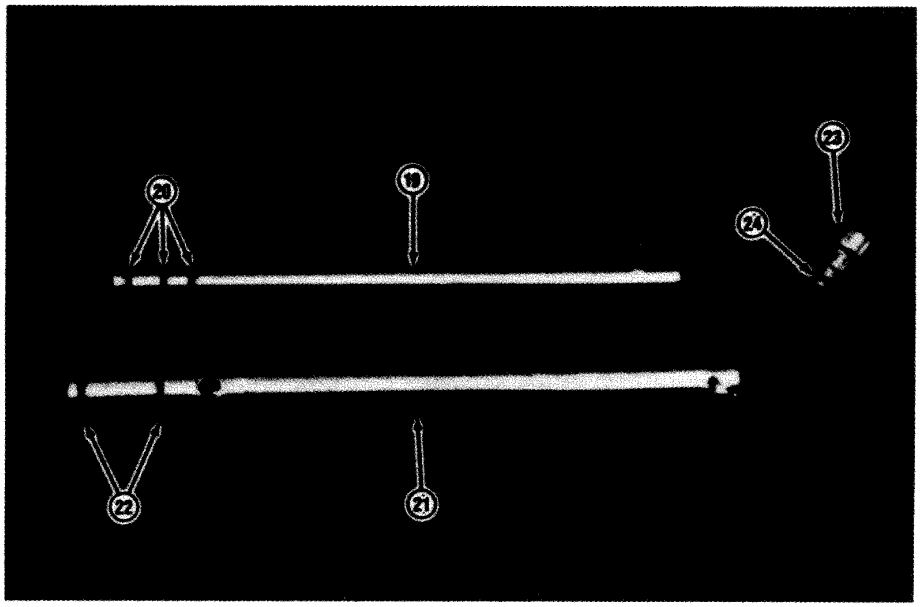
ITEM	DESCRIPTION	FUNCTION
1	Beater Assembly	Turns inside freezing cylinder to blend air and mix and eject product. The beater should turn clockwise when observed from the operator's end. Drives scraper blades.
2	Scraper Blades	To scrape frozen product off inside wall of freezing cylinder.
3	Drive Shaft	Connecting part from gear unit to beater. Shaft must be lubricated properly.
4	Seal (Drive Shaft)	Provides seal from product inside cylinder to external areas of freezer. Must be lubricated properly.



ITEM	DESCRIPTION	FUNCTION
5	Freezer Door Assembly	Covers the open end of the freezing cylinder and provides a port for frozen mix to be ejected.
6	Gasket (Freezer Door)	Provides a seal between the freezer door and the freezing cylinder. Do not lubricate.
7	Front Bearing (Freezer Door)	Allows beater to turn freely on hub of freezer door. Do not lubricate.
8	Draw Valve	Seals off mix port in freezer door. Opens port when raised allowing frozen mix to be ejected.
9	O-Ring (Draw Valve)	Provides seal for draw valve in freezer door. Must be lubricated properly.
10	Center Draw Valve	Seals off mix port in freezer door. Opens port when raised allowing frozen mix to be ejected.
11	Seal (Center Draw Valve)	Provides seal for draw valve in freezer door. Must be lubricated properly.
12	Adjustable Draw Handle	Raises or lowers the draw valve to eject or stop the flow of product from the freezing cylinder.
13	Pivot Pin	Allows a pivoting point for the draw handle to raise and lower the draw valve.
14	O-Ring (Pivot Pin)	Prevents pivot pin from slipping. Must be lubricated properly.
15	Prime Plug	When raised, allows undesired air to escape from freezing cylinder during priming.
16	O-Ring (Prime Plug)	Provides seal for prime plug in freezer door. Must be lubricated properly.
17	Handscrew	Tightening mechanism to secure door to freezing cylinder. Tighten equally.
18	Design Cap	Provides star design for product being ejected.

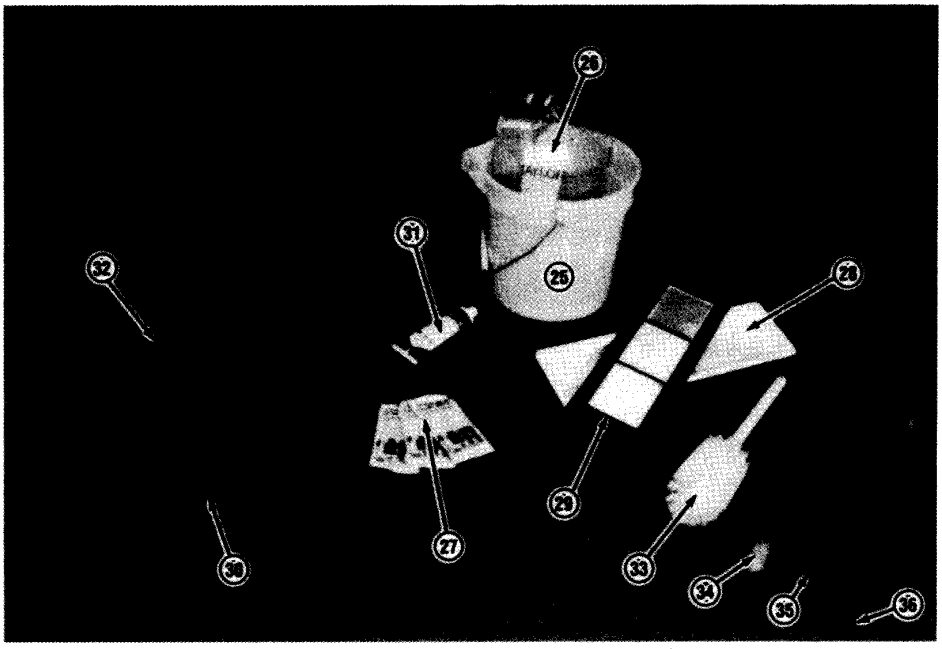


ITEM	DESCRIPTION	FUNCTION
19	Inner Air Tube Assembly	Regulates the amount of air and mix into freezing cylinder when used in conjunction with the outer air tube.
20	O-Ring (Inner Air Tube)	Creates a seal to the outer air tube. Must be lubricated properly.
21	Outer Air Tube Assembly	Regulates the amount of air and mix into the freezing cylinder when used in conjunction with the inner air tube.
22	O-Ring (Outer Air Tube)	Provides a seal around the mix inlet hole and outer air tube. Must be lubricated properly.
23	Air Orifice	Restricts the amount of air entering the freezing cylinder.
24	O-Ring (Air Orifice)	Provides a seal between the air orifice and assembled air tubes. Do not lubricate.



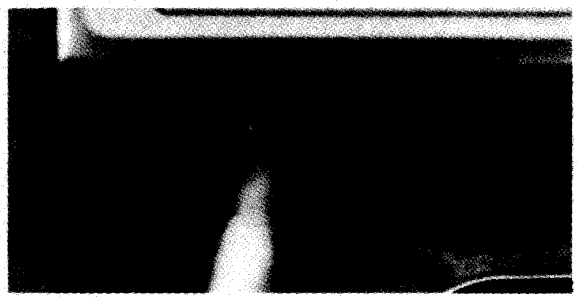
Accessories

ITEM	DESCRIPTION	FUNCTION
25	Pail (10 quart - 9.5 liter)	Used for cleaning and sanitizing freezer.
26	Tune-Up Kit Assembly	Kit that contains replacement parts for all wear items.
27	Kay-5 Sanitizer	Approved 100 PPM cleaning and sanitizing solution.
28	Front Drip Tray	Catches any excessive mix leakage from door spout.
29	Splash Shield	Helps to prevent any mix leakage from door spout from splashing out.
30	Rear Drip Pan	Used to collect any mix leakage from the rear shell bearing.
31	Taylor Lube	Approved lubricant for moving parts and wear items. Follow lubricating procedures in "Assembly" portion of Operating Procedures.
32	Mix Hopper Cover Assembly	Protects mix in mix hopper from any debris dropping in.
33	White Bristle Brush, 3″ x 7″	Use: Mix hopper.
34	White Bristle Brush, 1″ x 2″	Use: Freezer door, draw valve port.
35	Black Bristle Brush, 1″ x 2″	Use: Rear shell bearing.
36	Double-Ended Brush	Use: Freezer door port holes and all o-ring grooves.



Important: To the Operator

POWER SWITCH

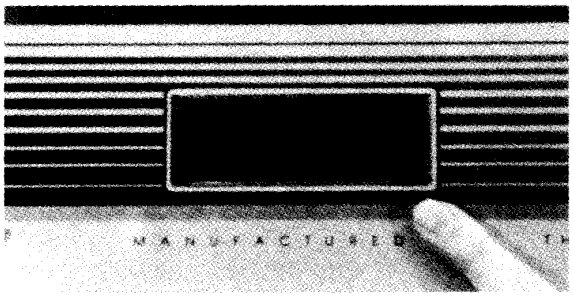


When placed in the ON position, the power switch allows SOFTECH control panel operation.

SECURITY SWITCH

There is a push-button switch located in the base pan towards the front of the machine. When the switch is in the ON position (raised) the keypad functions are disabled. The message SECURITY SWITCH ON will be displayed on the LCD screen. When the push-button switch is in the OFF position (depressed) the keypad functions are enabled.

LIQUID CRYSTAL DISPLAY



Located on the front control panel is the Liquid Crystal Display (LCD). The LCD is used to show the current mode of the freezer. If an error in the machine operation occurs, a warning tone will sound and the word "FAULT" will appear on the LCD.

LCD INDICATOR — "MIX LOW"

MODE:	**AUTO**	
MIX	**L=LOW**	**R=OK**

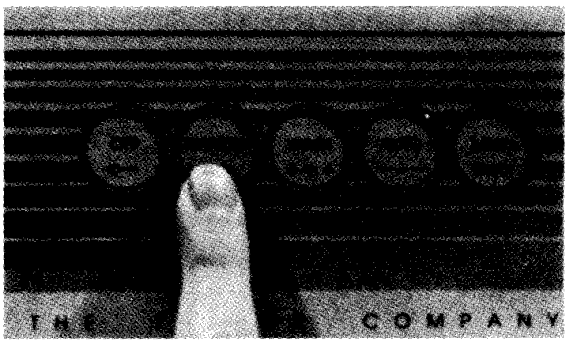
The word "LOW" will appear on the LCD next to the left or right freezing cylinder, indicating that the mix hopper has a low supply of mix and should be refilled as soon as possible.

LCD INDICATOR — "MIX OUT"

MODE:	**STANDBY**	
MIX	**L=OUT**	**R=OK**

The word "OUT" will appear on the LCD next to the left or right freezing cylinder, indicating that the mix hopper has an insufficient supply of mix to operate the freezer. At this time, the freezer will go into the "STANDBY" mode of operation. To return the freezer to the "AUTO" mode, fill the hopper with mix and press the word "AUTO." The freezer will automatically begin operation.

"STANDBY"



The Separate Hopper Refrigeration System (SHR) is a **standard feature** on SOFTECH Model 337. The SHR incorporates the use of a separate small refrigeration system to maintain the mix in the hopper below 40° F. (4.4° C.) to assure bacteria control and good quality product. During long "No Sale" periods, it is necessary to warm the product in the freezing cylinder to approximately 30° F. (-1.1 ° C.).

To activate the SHR, press the word "STANDBY." Lift and turn the inner air tube of the assembled air tubes so the pin rests on top of the outer air tube. This will close the hole in the assembled air tubes, preventing mix in the hopper from entering the freezing cylinder.

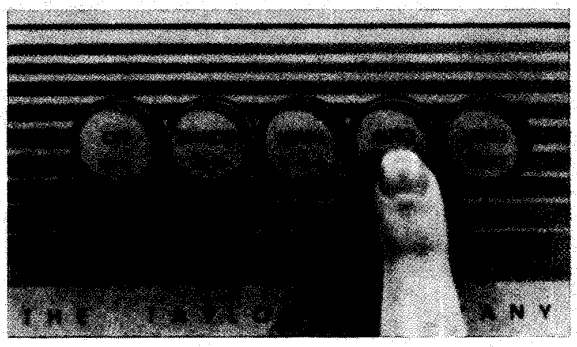
When the word "STANDBY" is pressed, STANDBY appears on the LCD indicating the "STANDBY" mode has been activated to maintain the mix in the hopper and freezing cylinder at a refrigerated temperature. In the "STANDBY" mode, the "WASH" and "AUTO" functions are automatically cancelled.

To resume normal operation, press the word "AUTO." When the unit cycles off, the product in the freezing cylinder will be at serving viscosity. At this time, adjust the inner air tube so that it rests in the bottom of the notch of the outer air tube. This will allow mix and air to enter the freezing cylinder.

"WASH"

When the word "WASH" is pressed, WASH appears on the LCD indicating beater motor operation.

"AUTO"



When the word "AUTO" is pressed, AUTO appears on the LCD indicating the main refrigeration system has been activated. In the "AUTO" mode, the "WASH" or "STANDBY" functions are automatically cancelled.

NOTE: To cancel any function, press the word "OFF" and the mode of operation will shut off.

MENU DISPLAY

OPERATOR MENU
A B C D E
EXIT MENU
<- - - - - -> **SEL**

The OPERATOR MENU is used to enter into the operating screens. To access the OPERATOR MENU simply press the word "MENU." The cursor will flash over the letter "A" indicating that this is screen "A." Use the arrow buttons to move to a different screen. Press the select button.

Screen "B" is FAULT DESCRIPTION. This screen will indicate what the fault is (see variable messages below). To see if more than one fault exists, press the select button. To cancel the alarm, correct the fault, then press the word "OFF." To return to the OPERATOR MENU, press the select button. To return to the main screen, press the select button again.

1. NO FAULT FOUND - There was no fault found in the machine.

2. BTR OVLD OR HPCO - Beater motor has gone off on overload or compressor high pressure cut-out. To reset the beater motor overload, press the word "OFF" to cancel the cycle. Place the power switch in the OFF position. Depress the reset button firmly. Place the power switch in the ON position. To clear a compressor high pressure cut-out fault, place the power switch in the OFF position. Wait 5 minutes for the machine to cool. Place the power switch in the ON position. Clear the tone.

3. COMP ON TOO LONG - Place power switch in the OFF position. Call service technician.

4. BTR CURRENT BAD - Place power switch in the OFF position. Call service technician.

5. HOPPER THERM BAD - Place power switch in the OFF position. Call service technician.

6. LEFT BRL THERM - Place power switch in the OFF position. Call service technician.

7. RIGHT BRL THERM - Place power switch in the OFF position. Call service technician.

8. HOPPER OVER TEMP - Hopper temperature has reached 45° F. (7.2° C.) or higher. Clear the tone. We recommend disassembly and brush cleaning of the freezer. Discard the mix.

9. BARREL OVER TEMP - Freezing cylinder temperature has reached 45° F. (7.2° C.) or higher. Clear the tone. We recommend disassembly and brush cleaning of the freezer. Discard the mix.

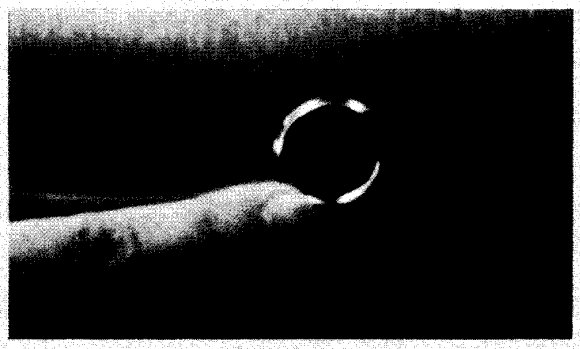
10. POWER FAILURE - Power failure interrupted normal operation. Clear the tone.

Screen "C" is SOFTWARE VERSION. This screen will indicate the software version being used. Press the select button once to return to the OPERATOR MENU, or twice to return to the main screen.

Screen "D" is CURRENT CONDITIONS. The current conditions screen displays the temperature of the freezing cylinder and the exit temperature of the hopper cooling system refrigerant. This screen also displays the number of draws that have been made from each freezing cylinder. (If a draw is made from the center door spout, one is added to both the right and left draw count.) When the unit is taken out of the AUTO mode, the number of draws will reset to zero. Press the select button once to return to the OPERATOR MENU, or twice to return to the main screen.

Screen "E" is SERVICE MENU. This screen can only be accessed by a service technician.

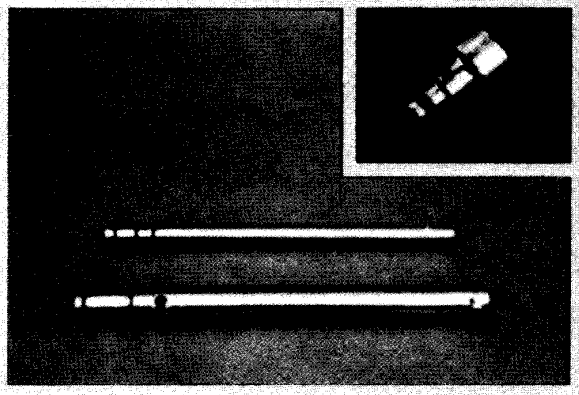
RESET BUTTON



The reset button is located in the lower front panel. The reset protects the beater motor from an overload condition. Should an overload occur, the reset mechanism will trip. An audible warning will sound, and the word "FAULT" will appear on the LCD. To properly reset the freezer, press the word "OFF" to cancel cycle. Place power switch in the OFF position. Depress the reset button firmly. Place power switch in the ON position. Press the word "WASH" and observe the freezer's performance. Open the side access panel to check if beater motor is turning the drive shafts in a clockwise direction (from operator end) without binding.

If it is turning properly, press the word "OFF" to cancel cycle. Press the word "AUTO" to resume normal operation. If freezer shuts down again, contact service technician.

AIR TUBE

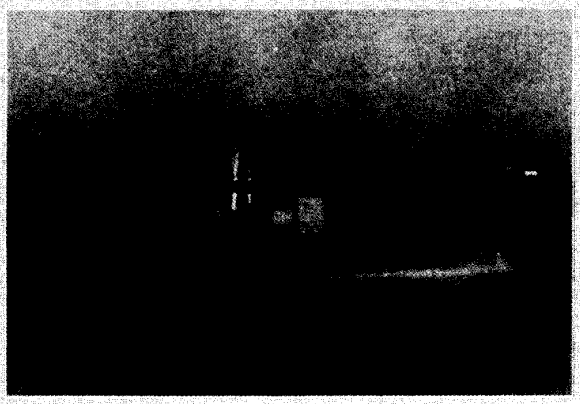


After priming the machine, lubricate the o-rings on the inner and outer air tubes and place the assembled air tube into the mix inlet hole. Every time the draw handle is raised, new mix and air from the hopper will flow down into the freezing cylinder. This will keep the freezing cylinder properly loaded and will maintain overrun.

The air orifice is used to meter a certain amount of air into the freezing cylinder to maintain overrun and to allow enough mix to enter the freezing cylinder after a draw.

During long "No Sale" periods, lift and turn the inner air tube of the assembled air tubes so the pin rests on top of the outer air tube. This will close the hole in the assembled air tubes, preventing any mix in the hopper from entering the freezing cylinder.

ADJUSTABLE DRAW HANDLE

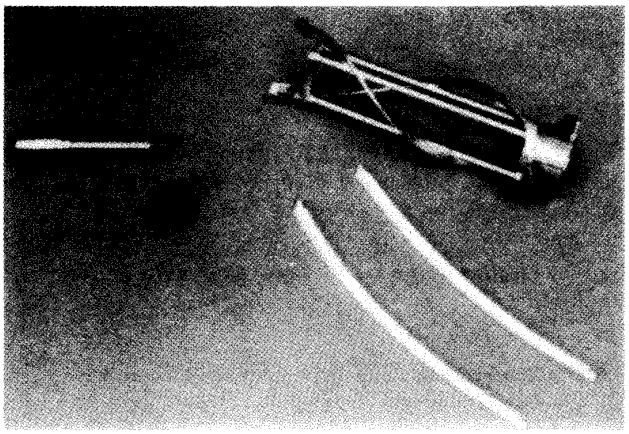


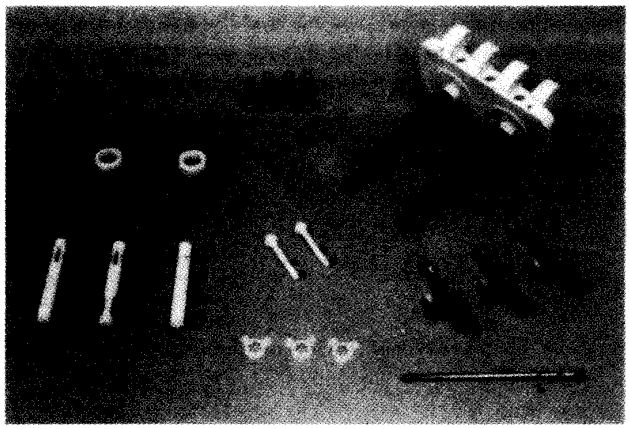
This unit features an adjustable draw handle to provide the best portion control, giving a better consistency quality to your product, and controlling costs. The draw handle should be adjusted to provide a flow rate of 5 to 7-1/2 oz. of product by weight per 10 seconds. To INCREASE the flow rate, turn the screw COUNTER-CLOCKWISE and CLOCKWISE to DECREASE the flow rate. In addition, for purposes of "Sanitizing" and "Rinsing," the flow rate can be increased by removing the pivot pin and placing the restrictive bar on the TOP. When drawing product, **always** have the restrictive bar on the BOTTOM.

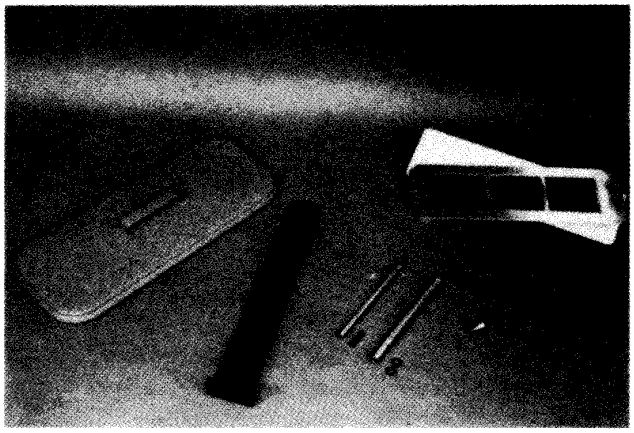
Operating Procedures

The Model 337 contains two 2.8 quart (2.7 liter) capacity freezing cylinders and two 14 quart (13.2 liter) mix hoppers. The mix flows by **gravity** from the hopper to the freezing cylinder through an air tube. The Model 337 is a counter model with two freezing cylinders for two individual flavors or an equal combination of both for a twist effect.

We begin our instructions at the point where we enter the store in the morning and find the parts disassembled and laid out to air dry from the previous night's cleaning.







These opening procedures will show you how to assemble these parts into the freezer, sanitize them, and prime the freezer with fresh mix in preparation to serve your first portion.

If you are disassembling the machine for the first time or need information to get to this starting point in our instructions, turn to page 24, "Disassembly," and start there.

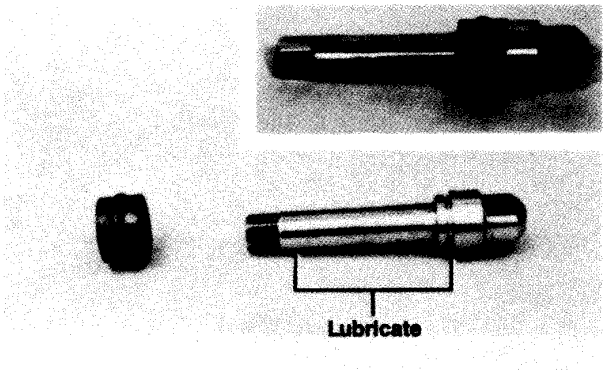
ASSEMBLY

NOTE: When lubricating parts, use an approved food grade lubricant (Example: Taylor Lube).

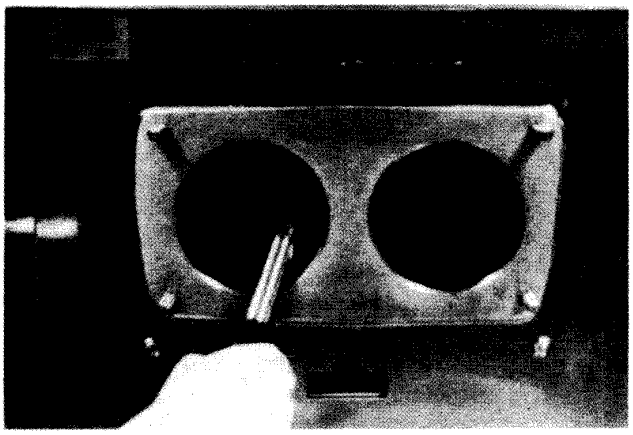
MAKE SURE THE POWER SWITCH IS IN THE OFF POSITION.

Step 1

Install drive shaft. Lubricate the groove and shaft portion that comes in contact with the bearing on the beater drive shaft. Slide the seal over the shaft and groove until it snaps into place. **DO NOT** lubricate the hex end of the drive shaft. Fill the inside portion of the seal with 1/4" more lubricant and lubricate the flat side of the seal that fits onto the rear shell bearing.

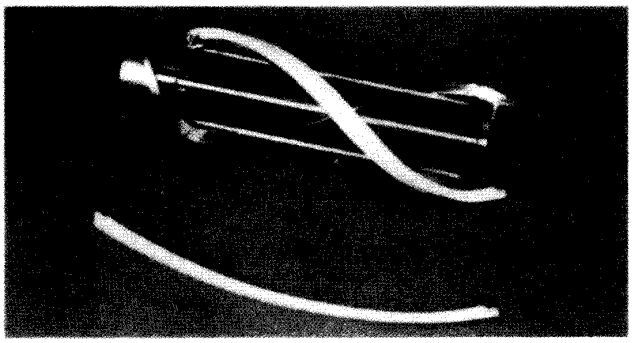


Insert the drive shaft into the freezing cylinder, hex end first, and into the rear shell bearing until the seal fits securely over the rear shell bearing. Engage the hex end firmly into the drive coupling. Be sure the drive shaft fits into the drive coupling without binding.

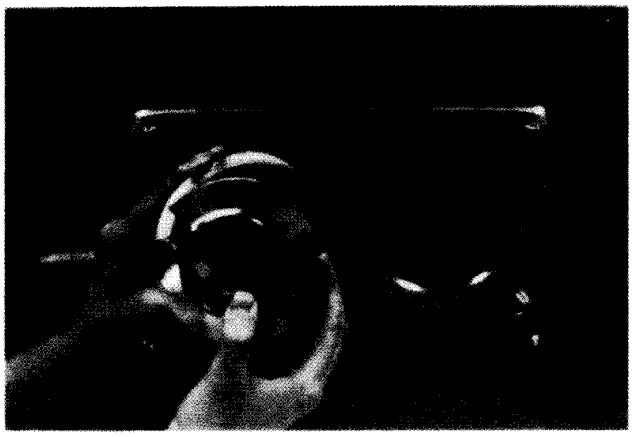


Step 2

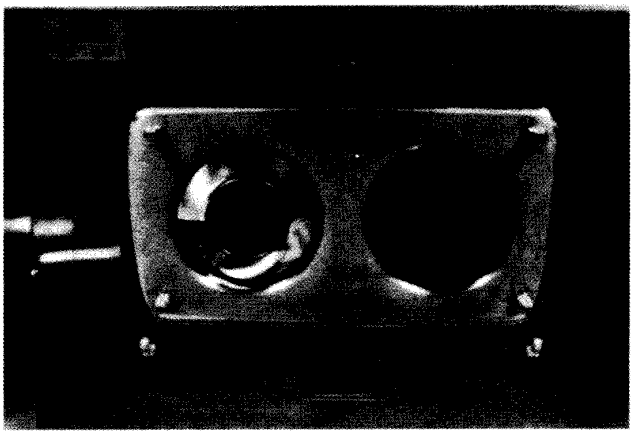
Take one of the scraper blades and slip it under the hook at the front of the beater. Wrap the blade around the beater following the helix and pushing the blade down onto the helix as you wrap. At the back end of the beater, slip the blade under the hook. **Repeat this step** for the second scraper blade.



Holding the beater securely, slide the beater into the freezing cylinder about one-third of the way in. Looking into the freezing cylinder, align the hole at the rear of the beater with the flats on the end of the drive shaft.



Slide the beater the remainder of the way into the freezing cylinder and over the end of the drive shaft. The beater should fit snugly but not so tight that the beater cannot be turned slightly to engage the drive shaft. When in position, the beater will not protrude beyond the front of the freezing cylinder.



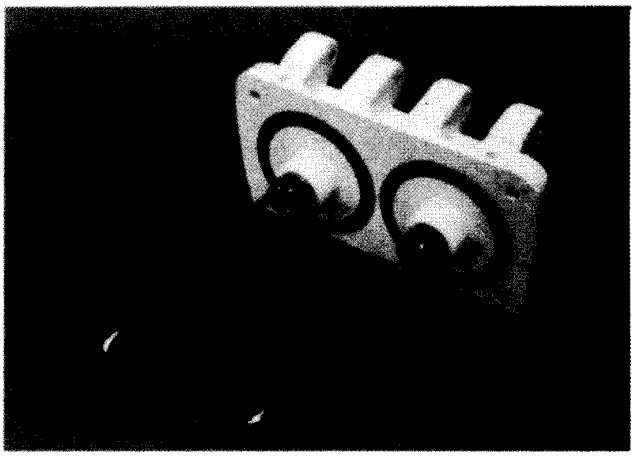
If the beater slides in too easily with little or no resistance, there will not be enough force against the beater to hold the blades in place. If this is the case, contact your local authorized Taylor distributor.

Repeat steps 1 and 2 for the other side of the freezer.

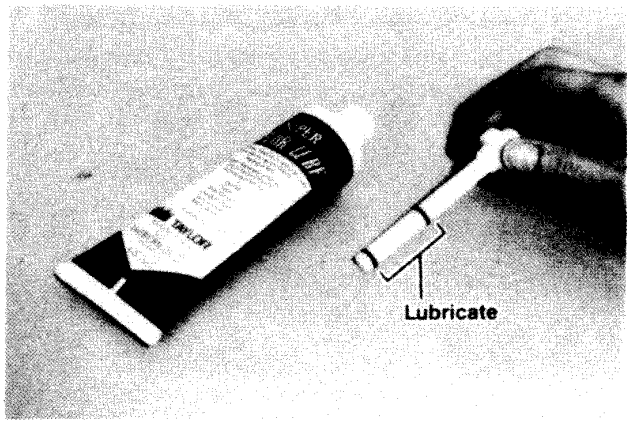
Step 3

Assemble freezer door. Place the large rubber gaskets into the grooves on the back side of the freezer door.

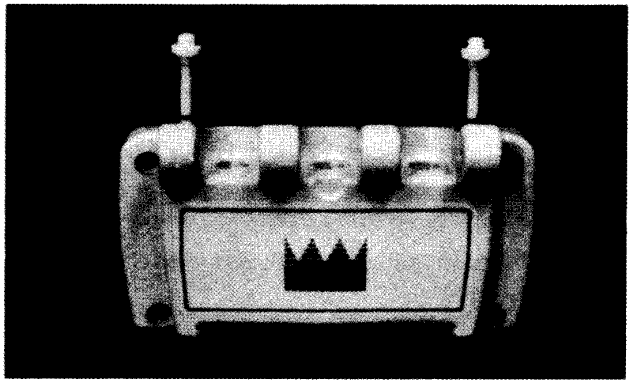
Slide the white plastic front bearings over the baffle rods onto the bearing hubs making certain that the flanged end of the bearing is resting against the freezer door. DO NOT LUBRICATE THE GASKETS OR FRONT BEARINGS.



Slide the two o-rings into the grooves on the prime plugs. Apply an even coat of Taylor Lube to the o-rings and shafts.

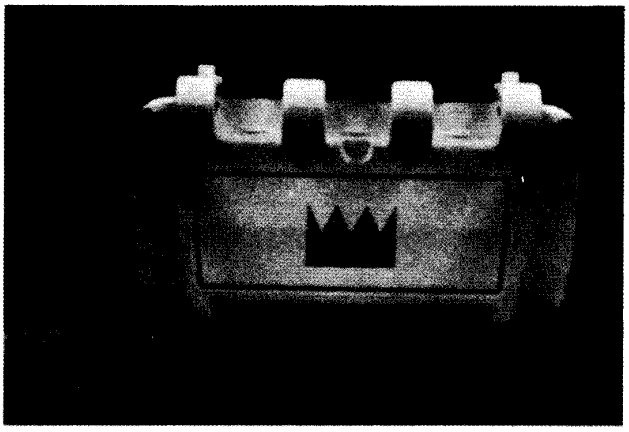


Insert the prime plugs into the holes in the top of the freezer door and push down.



Step 4

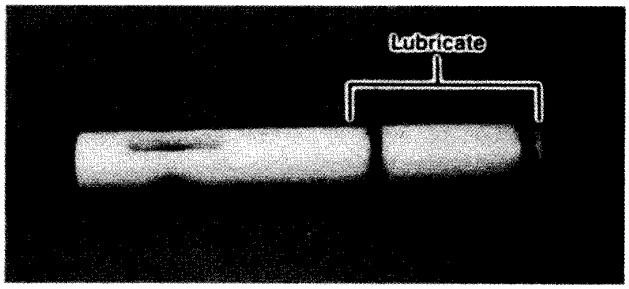
Install freezer door. Insert the baffle rods through the opening in the beaters and seat the door flush with the freezing cylinder. With the door seated on the freezer studs, install the handscrews. Tighten equally in a criss-cross pattern to insure the door is snug.



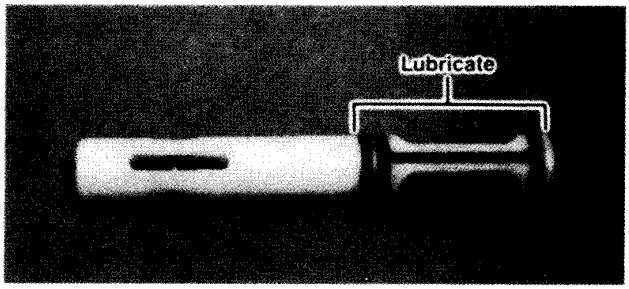
NOTE: The short handscrews go on the bottom and the long handscrews go on top.

Step 5

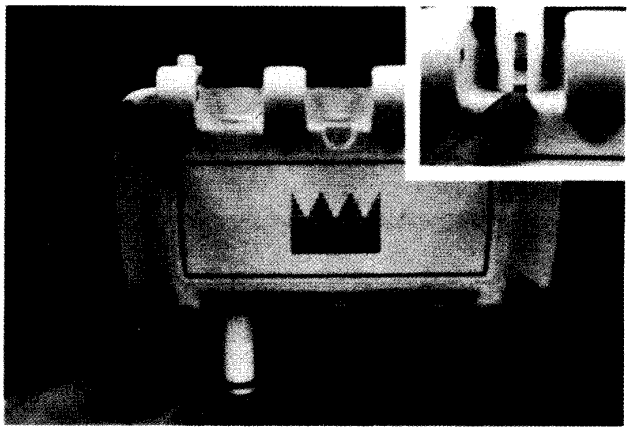
Install draw valves. Slide the two o-rings into the grooves or the draw valves and lubricate.



The center draw valve uses a seal and an o-ring. Slide the o-ring and seal into the grooves and lubricate.

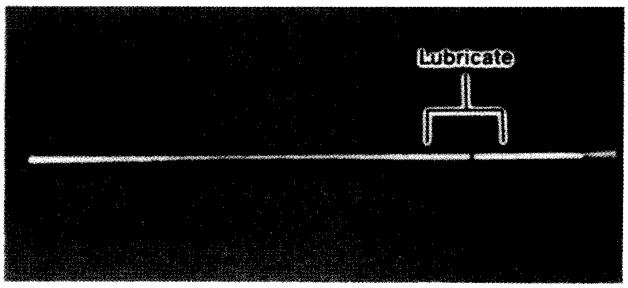


Lubricate the inside of the freezer door spouts, top and bottom and insert the draw valves from the **bottom** until the slot in the draw valves comes into view.

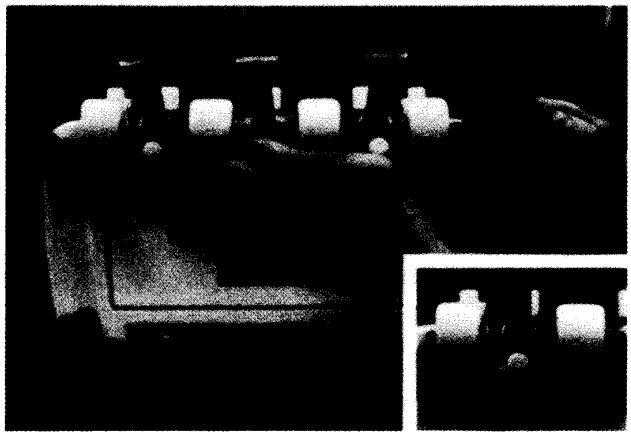


Step 6

Install adjustable draw handles. Slide the o-ring into the groove on the pivot pin and lubricate.

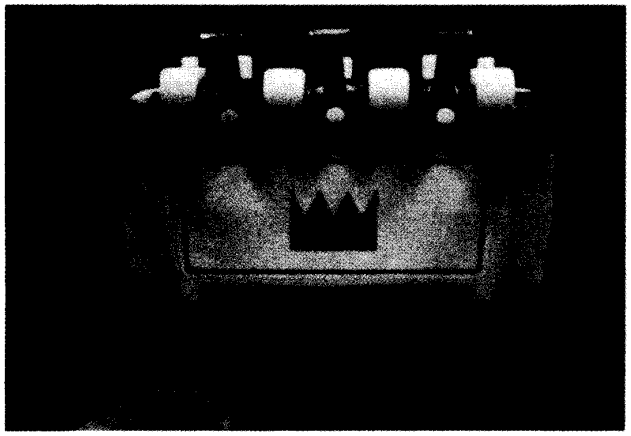


Slide the fork of the draw handle over the bar in the slot of the draw valve, starting from the right. Slide pivot pin through each draw handle as you insert them into the draw valves.



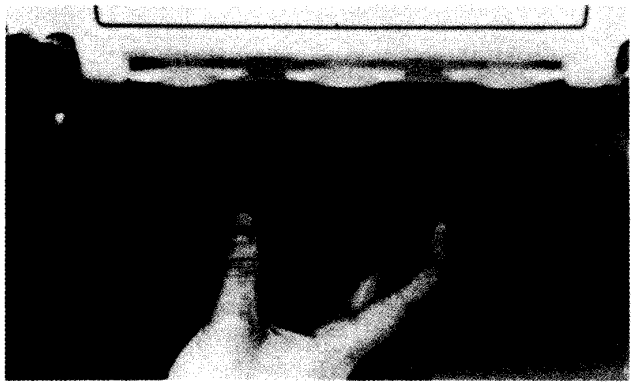
NOTE: This unit features adjustable draw handles to provide the best portion control, giving a better consistency quality to your product, and controlling costs. The draw handles can be adjusted for different flow rates. See page 16 for more information on adjusting these handles.

Step 7
Snap the design caps over the end of the door spouts.

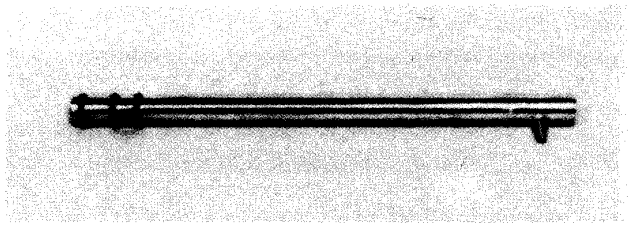


Step 8
Install front drip tray and splash shield under the door spouts.

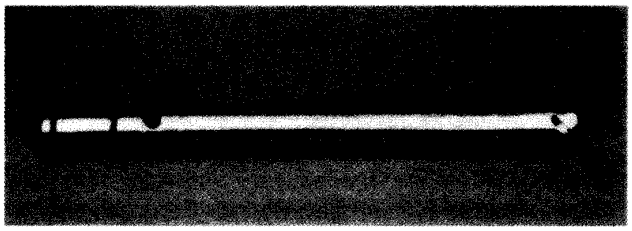
Step 9
Slide the rear drip pan into the hole in the front panel.



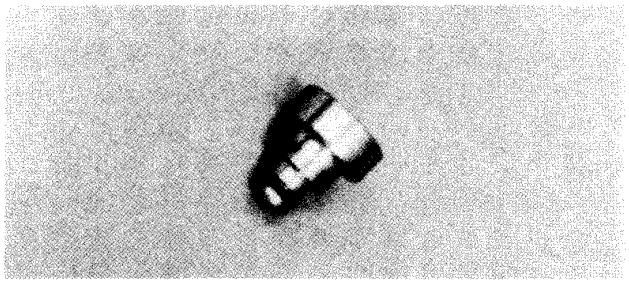
Step 10
Slide the three o-rings into the grooves in the inner air tube.



Slide the two o-rings into the grooves of the outer air tube.



Slide the small o-ring into the groove of the air orifice. Do not lubricate this o-ring.



NOTE: Make sure the hole in the air orifice is clean and not blocked. If the hole in the air orifice should become plugged, use soap and hot water to clear the hole. **Caution should be used not to enlarge the hole size in the air orifice.**

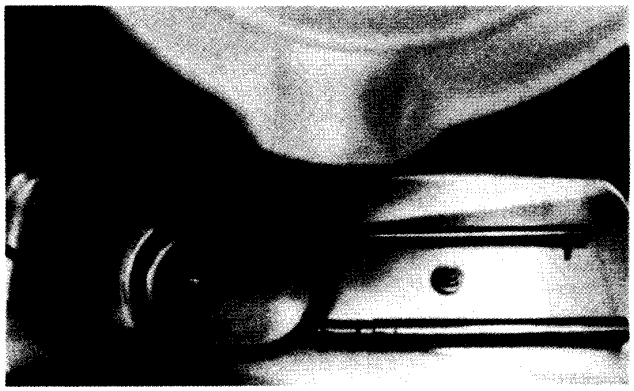
Step 11
Lay the inner air tube, outer air tube, and air orifice in the bottom of the mix hopper for sanitizing.

Repeat steps 10 and 11 for the other side of the freezer.

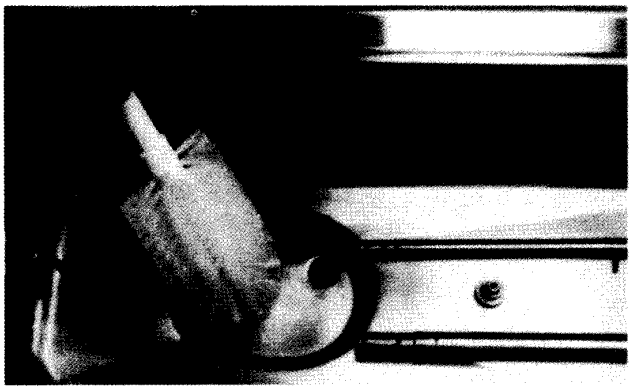
SANITIZING

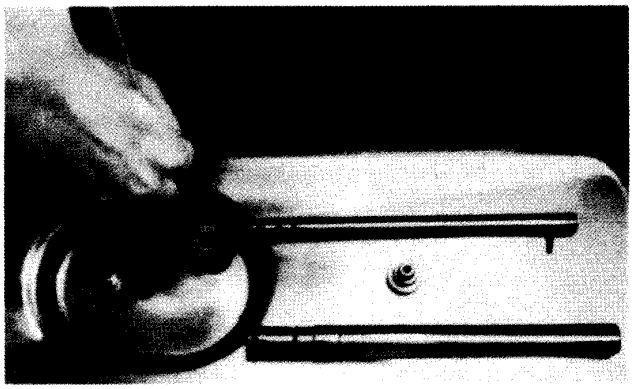
Step 1
Prepare two gallons (7.6 liters) of an approved 100 PPM sanitizing solution (Example: Kay-5) with WARM WATER ACCORDING TO THE MANUFACTURER'S SPECIFICATIONS.

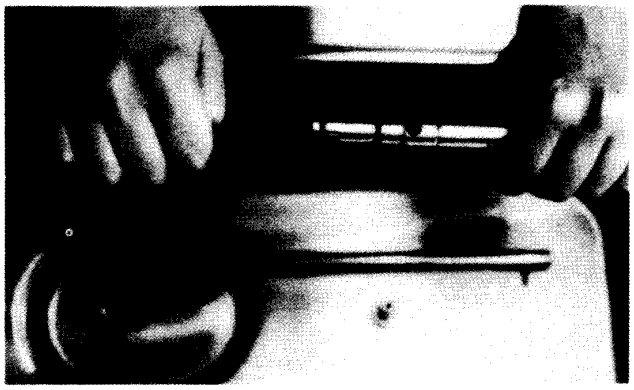
Step 2
Pour the two gallons (7.6 liters) of sanitizing solution into the hopper and allow it to flow into the freezing cylinder.



Step 3
While the solution is flowing into the freezing cylinder, brush clean the mix hopper. In cleaning the hopper, take particular care in brushing the mix level sensing probe on the rear wall of the hopper, the mix out probe, the mix inlet hole, and the inner and outer air tubes.



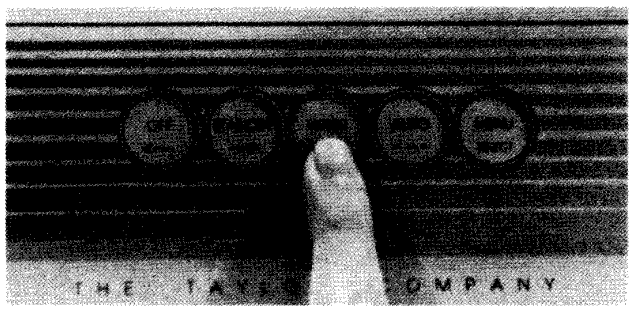




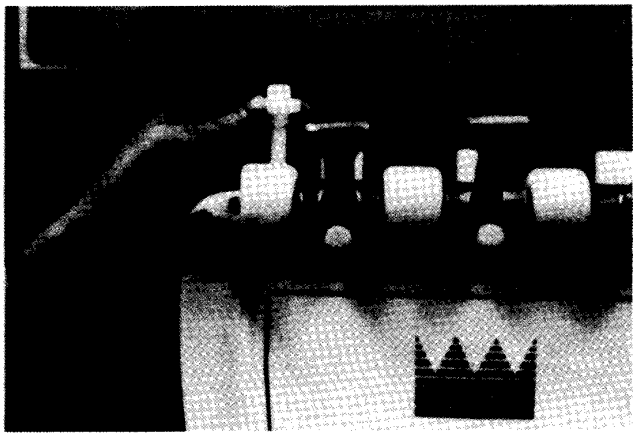
Repeat steps 1 through 3 for the other side of the freezer.

Step 4
Place the power switch in the ON position.

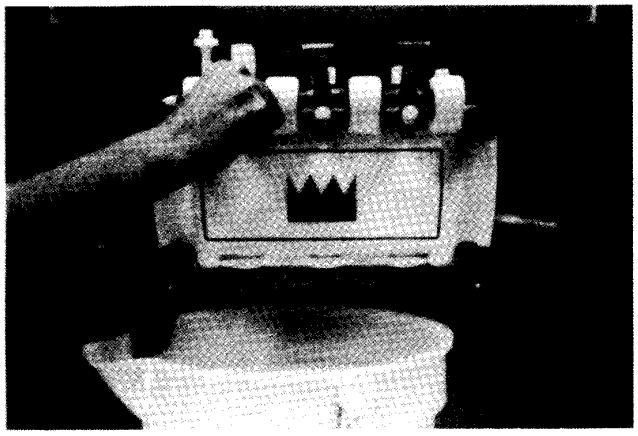
Step 5
Press the word "WASH." This will cause the sanitizing solution in the freezing cylinder to be agitated. Allow to agitate for five minutes.



Step 6
Place an empty pail beneath the door spout and raise the prime plug.



Step 7
When a **steady** stream of sanitizing solution is flowing from the prime plug opening in the bottom of the freezer door, lower the draw handle. Draw off all the sanitizing solution.



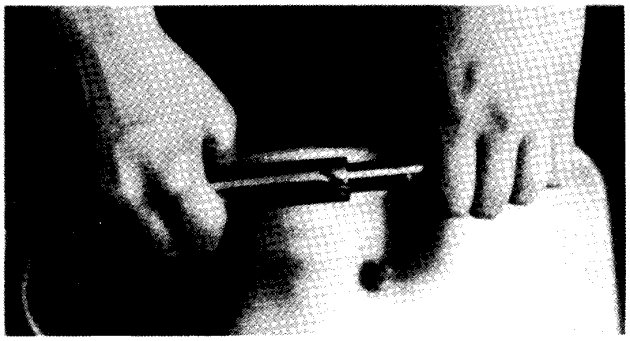
NOTE: Momentarily pull center draw handle down to sanitize center door spout.

Repeat steps 6 and 7 for the other side of the freezer.

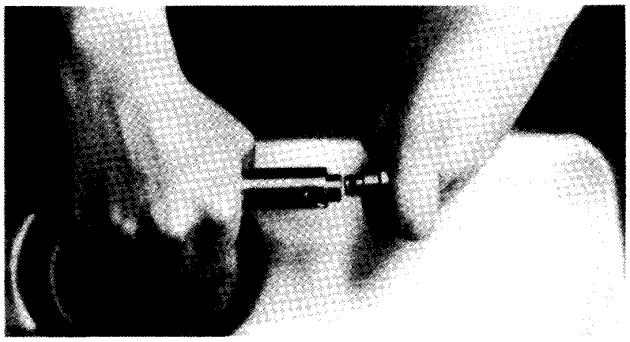
Step 8
Once the sanitizer stops flowing from the door spout, raise the draw handle and press the word "OFF" cancelling the beater motor operation.

NOTE: You have just sanitized the freezer, therefore, **be sure your hands are sanitized** before going on in these instructions.

Step 9
Lubricate the o-rings on the inner air tubes and outer air tubes. **DO NOT** lubricate o-ring on air orifice. Place inner air tubes inside the outer air tubes.



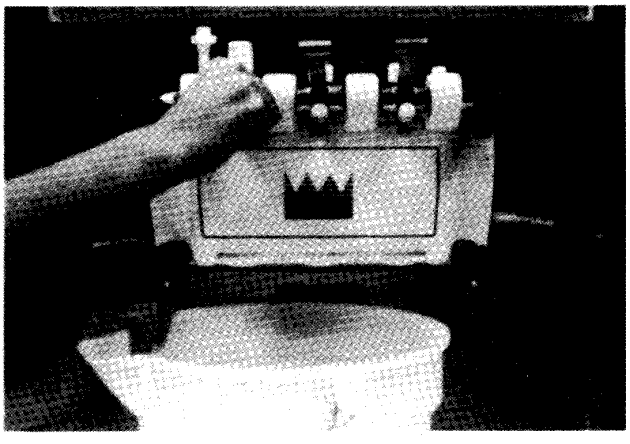
Install air orifices into the hole in the top of the inner air tubes.



Step 10
Stand the assembled air tubes in the corner of each hopper.

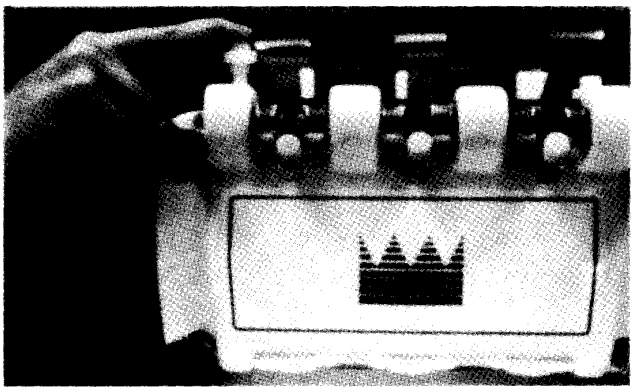
PRIMING

Step 1
With a pail beneath the door spout, lower the draw handle. Be sure the prime plug is still in the "UP" position. Pour two gallons (7.6 liters) of **fresh** mix into the mix hopper and allow it to flow into the freezing cylinder. This will force out any remaining sanitizing solution. When full strength mix is flowing from the door spout, raise the draw handle.



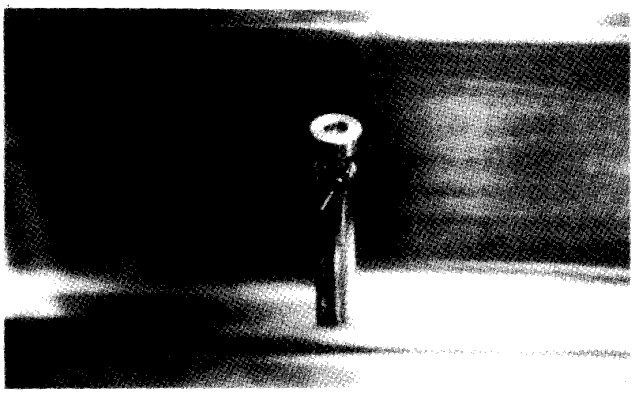
NOTE: Use only fresh mix when priming the freezer.

Step 2
Once a **steady** stream of mix starts to flow from the prime plug opening in the bottom of the freezer door, push down the prime plug.



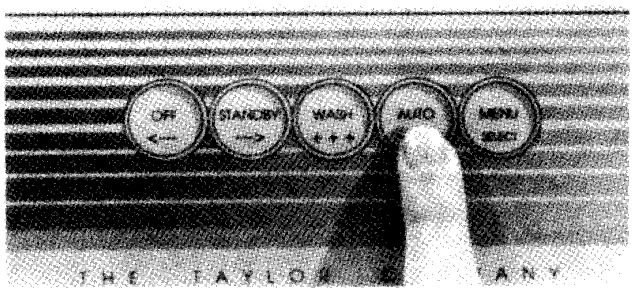
Step 3
Install the assembled air tube into the mix inlet hole in the mix hopper.

Step 4
The pin on the inner air tube should be turned and positioned at the bottom of the notch in the outer air tube. This will align the holes in the air tubes and allow mix and air to enter the freezing cylinder.



Repeat steps 1 through 4 for the other side of the freezer.

Step 5
Press the word "AUTO." The word "AUTO" will appear on the LCD, indicating the main refrigeration system is operating. When the unit cycles off, the product will be at serving viscosity.



Step 6
Fill the hopper with mix. The word "OK" will appear on the LCD when the mix level comes in contact with the mix level sensing probe on the rear wall of the hopper.

Step 7
Place the mix hopper cover in position over the mix hopper.

Repeat steps 6 and 7 for the other side of the freezer.

CLOSING PROCEDURE

To disassemble your unit, the following items will be needed:

- Two cleaning pails
- Sanitized stainless steel rerun can with lid
- Necessary brushes (provided with freezer)
- Cleaner
- Single service towels

DRAINING PRODUCT FROM THE FREEZING CYLINDER

Step 1
Press the word "OFF," cancelling compressor and beater motor operation.

Step 2
Remove the hopper cover and assembled air tube and take these parts to the sink for cleaning.

Step 3
With a sanitized pail beneath the door spout, press the word "WASH." Lower the draw handle and drain the remaining product from the freezing cylinder and mix hopper.

Step 4
When the flow of product stops, press the word "OFF," and raise the draw handle. If local health codes permit, empty the rerun into a sanitized stainless steel can. Cover the container and place it in the walk-in cooler.

Repeat steps 2 through 4 for the other side of the freezer.

FOLLOW YOUR LOCAL HEALTH CODES

RINSING

Step 1
Pour two gallons (7.6 liters) of **cool** clean water into the mix hopper. With the brushes provided, scrub the mix hopper, mix inlet hole and mix level sensing probes.

Step 2
With a pail beneath the door spout, raise the prime plug and press the word "WASH."

Step 3
When a steady stream of rinse water is flowing from the prime plug opening in the bottom of the freezer door, lower the draw handle. Drain all the rinse water from the freezing cylinder, raise the draw handle and press the word "OFF" cancelling the "WASH" mode.

Repeat steps 1 through 3 for the other side of the freezer.

CLEANING

Step 1
Prepare two gallons (7.6 liters) of an approved cleaning solution (Example: Kay-5) with WARM WATER ACCORDING TO THE MANUFACTURER'S SPECIFICATIONS.

Step 2
Push down the prime plug. Pour the two gallons (7.6 liters) of cleaning solution into the mix hopper.

Step 3
While the solution is flowing into the freezing cylinder, brush clean the mix hopper, mix level sensing probes and mix inlet hole.

Step 4
Press the word "WASH." This will cause the cleaning solution in the freezing cylinder to be agitated.

Step 5
Place an empty pail beneath the door spout and raise the prime plug.

Step 6
When a steady stream of cleaning solution is flowing from the prime plug opening in the bottom of the freezer door, lower the draw handle. Draw off all of the solution.

Step 7
Once the cleaner stops flowing from the door spout, raise the draw handle and press the word "OFF" cancelling the "WASH" mode.

Repeat steps 1 through 7 for the other side of the freezer.

DISASSEMBLY

Step 1
BE SURE THE POWER SWITCH IS IN THE **OFF** POSITION.

Step 2
Remove the handscrews, freezer door, beaters and scraper blades and drive shafts from the freezing cylinders and take to the sink for cleaning.

Step 3
Remove the front drip tray and splash shield.

BRUSH CLEANING

Step 1
Prepare a sink with an approved cleaning solution (Example: Kay-5) in WARM WATER ACCORDING TO THE MANUFACTURER'S SPECIFICATIONS. If another approved cleaner is used, dilute according to label instructions. (**IMPORTANT:** Follow label directions, as too STRONG of a solution can cause parts damage, while too MILD of a solution will not provide adequate cleaning.) Make sure all brushes provided with the freezer are available for brush cleaning.

Step 2
Remove the seals from the drive shafts.

Step 3
From the freezer door remove:

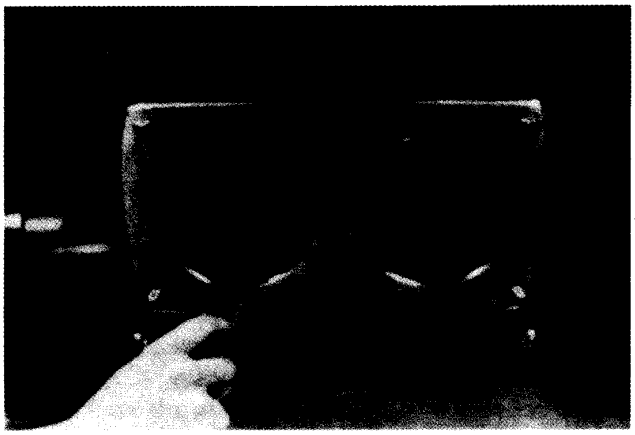
1. gaskets
2. front bearings
3. pivot pin
4. adjustable draw handles
5. design caps
6. draw valves
7. prime plugs

Remove all o-rings.

NOTE: To remove o-rings, use a single service towel to grasp the o-ring. Apply pressure in an upward direction until the o-ring pops out of its groove. With the other hand, push the top of the o-ring forward and it will roll out of the groove and can be easily removed. If there is more than one o-ring to be removed, always remove the rear o-ring first. This will allow the o-ring to slide over the forward rings without falling into the open grooves.

Step 4
From the inner and outer air tubes, remove the o-rings and air orifices. Remove the o-rings from the air orifices.

Step 5
Return to the freezer with a small amount of cleaning solution. Brush clean the rear shell bearings at the back of the freezing cylinders with the black bristle brush.



Step 6
Remove the rear drip pan from the front panel and take to the sink for cleaning.

NOTE: If the drip pan is filled with an excessive amount of mix, refer to the Troubleshooting Guide.

Step 7
Thoroughly brush clean all disassembled parts in the cleaning solution making sure all lubricant and mix film is removed. Take particular care to brush clean the draw valve cores in the freezer door. Place all the cleaned parts on a clean dry surface to air dry overnight.

Step 8
Wipe clean all exterior surfaces of the freezer.

Important: Operator Checklist

DURING CLEANING AND SANITIZING:

Cleaning and sanitizing schedules are governed by your State or local regulatory agencies and must be followed accordingly. The following check points should be stressed during the cleaning and sanitizing operations. **WE RECOMMEND DAILY CLEANING AND SANITIZING.**

ALWAYS FOLLOW LOCAL HEALTH CODES

TROUBLESHOOTING BACTERIA COUNT:

- ☐ 1. Thoroughly clean and sanitize machine regularly, including complete disassembly and brush cleaning.
- ☐ 2. Use all brushes supplied for thorough cleaning. The brushes are specially designed to reach all mix passageways.
- ☐ 3. Use the white bristle brush to clean the mix inlet hole which extends from the mix hopper down to the rear of the freezing cylinder.
- ☐ 4. Use the black bristle brush to thoroughly clean the rear shell bearing located at the rear of the freezing cylinder. Be sure to have a generous amount of cleaning solution on the brush.
- ☐ 5. IF LOCAL HEALTH CODES PERMIT THE USE OF RERUN, make sure the mix rerun is stored in a sanitized, covered stainless steel container and used the following day. DO NOT prime the machine with rerun. When using rerun, skim off the foam and discard, then mix the rerun with fresh mix in a ratio of 50/50 during the days operation.
- ☐ 6. On a designated day of the week, run the mix as low as feasible and discard after closing. This will break the rerun cycle and reduce the possibility of high bacteria and coliform counts.
- ☐ 7. Properly prepare the cleaning and sanitizing solutions. Read and follow label directions carefully. Too strong of a solution may damage the parts and too weak of a solution will not do an adequate job of cleaning or sanitizing.
- ☐ 8. Temperature of mix in walk-in cooler or mix hopper should be below 40° F. (4.4° C.).

REGULAR MAINTENANCE CHECKS:

- ☐ 1. Replace scraper blades that are nicked or damaged. Before installing beater assembly, be certain that scraper blades are properly attached to the helix.
- ☐ 2. Check rear shell bearing for signs of wear (example: excessive mix leakage in rear drip pan).
- ☐ 3. Using a screwdriver and cloth towel, keep the rear shell bearing and the female hex drive socket clean and free of lubricant and mix deposits.
- ☐ 4. Dispose of o-rings and seals if they are worn, torn or fit too loosely and replace with new ones.
- ☐ 5. Follow all lubricating procedures as outlined in "Assembly."
- ☐ 6. If your machine is air cooled, check the condensers for accumulation of dirt and lint. Dirty condensers will reduce the efficiency and capacity of the machine. Condensers must be cleaned **monthly. Never** use screwdrivers or other metal probes to clean between the fins.
- ☐ 7. If your machine is water cooled, check the water lines for kinks or leaks. Kinks can occur when the machine is moved back and forth for cleaning and maintenance purposes. Deteriorated or cracked water lines should be replaced by an authorized Taylor distributor.

WINTER STORAGE

If your place of business is closed during the winter months, it is important to protect the freezer by following certain precautions, particularly if the building is to be left unheated and subject to freezing conditions.

Disconnect the freezer from the main power source to prevent possible electrical damage.

On water cooled freezers, disconnect the water supply. Relieve pressure on spring in water valve. Use air pressure on the outlet side to blow out any remaining water in the condenser, and then add a liberal amount of permanent type auto anti-freeze. **This is extremely important.** Failure to follow this procedure may cause severe and costly damage to the refrigeration system.

Wrap detachable parts of the freezer such as beater and blades, drive shaft and freezer door, and place in a protected dry place. Rubber trim parts and gaskets can be protected by wrapping with moisture-proof paper. All parts should be thoroughly cleaned of dried mix or lubrication accumulations which attract mice and other vermin.

Operator's Troubleshooting Guide

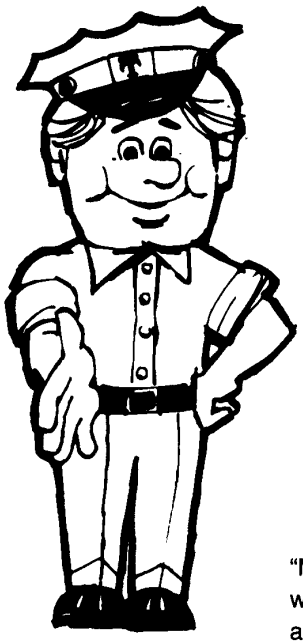
PROBLEM	PROBABLE CAUSE	REMEDY	PAGE REFER.
1. No product being dispensed with draw valve open and machine in "AUTO" mode.	a. Freeze-up in mix inlet hole.	a. Call service technician to adjust mix hopper temperature.	—
	b. Beater motor out on reset.	b. Reset freezer.	15
	c. Beater rotating counter-clockwise from operator end.	c. Contact service technician to correct rotation to clockwise from operator end.	—
	d. Circuit breaker off or blown fuse.	d. Turn breaker on or replace fuse.	—
	e. Air orifice not installed.	e. Install in air tube.	22
2. Product too stiff.	a. T.Q.C. set too cold.	a. Contact service technician.	—
	b. Assembled air tubes incorrectly installed.	b. Pin on inner air tube must be positioned at the bottom of the notch in the outer air tube.	23
	c. Air orifice not installed.	c. Install in air tube.	22
3. Product too soft.	a. T.Q.C. set too warm.	a. Contact service technician.	—
	b. Not enough air space around unit. (A/C)	b. Allow for adequate air flow across the condenser.	5
	c. Worn scraper blades.	c. Replace regularly.	29
	d. Dirty condenser. (A/C)	d. Clean monthly.	26
	e. Out-of-date mix.	e. Use only fresh mix.	—
	f. Loss of water. (W/C)	f. Locate cause of water loss and correct.	—
4. Mix in mix hopper too cold.	a. Temperature out of adjustment.	a. Call service technician.	—
5. Mix in mix hopper too warm.	a. Temperature out of adjustment.	a. Call service technician.	—
	b. Mix hopper cover not in position.	b. Place cover in position.	23
6. Drive shaft stuck in drive coupling.	a. Rounded corners of drive shaft, coupling or both.	a. Call service technician to correct cause and replace the necessary components. Do not lubricate hex end of drive shaft.	17
	b. Mix and lubricant collected in drive coupling.	b. Brush clean rear shell bearing area regularly.	25
7. Freezing cylinder walls scored.	a. Beater assembly bent.	a. Call service technician to repair or replace beater and to correct cause of insufficient mix in freezing cylinder.	—
	b. Missing or worn front bearing on freezer door.	b. Install or replace front bearing.	18/29

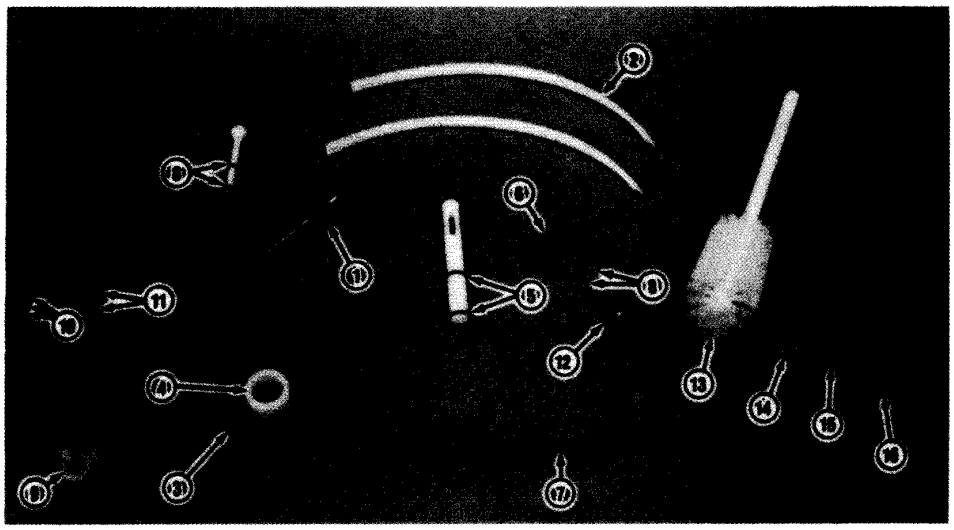
PROBLEM	PROBABLE CAUSE	REMEDY	PAGE REFER.
8. Excessive mix leakage into rear drip pan.	a. Missing or worn drive shaft seal on drive shaft.	a. Install or replace regularly.	17/29
	b. Worn rear shell bearing.	b. Call service technician to replace rear shell bearing.	—
9. Excessive mix leakage from door spout.	a. Missing or worn draw valve o-rings or seal.	a. Install or replace regularly.	19/29
	b. Inadequate lubrication of draw valve o-rings or seal.	b. Lubricate properly.	19
	c. Wrong type lubricant being used (Example: petroleum base lubricant).	c. Use proper lubricant (Example: Taylor Lube).	17
10. No freezer operation after pressing the word "AUTO."	a. Unit unplugged.	a. Plug into wall receptacle.	—
	b. Circuit breaker off or blown fuse.	b. Turn breaker on or replace fuse.	—
	c. Power switch in the OFF position.	c. Place power switch in the ON position.	21
	d. Mix out condition.	d. Fill mix hopper with mix.	23
	e. Beater motor out on reset.	e. Reset freezer.	15
11. Product not feeding into freezing cylinder.	a. Inadequate level of mix in mix hopper.	a. Fill mix hopper with mix.	23
	b. Mix inlet hole frozen up.	b. Mix hopper temperature needs adjustment. Call service technician.	—
	c. Assembled air tubes installed incorrectly.	c. Pin on inner air tube must be positioned at the bottom of the notch in the outer air tube.	23
	d. Air orifice not installed.	d. Install in air tube.	22

Parts Replacement Schedule

ITEM	DESCRIPTION	EVERY 3 MONTHS	EVERY 6 MONTHS	ANNUALLY
1	Drive Shaft Seal	X		
2	Scraper Blade	Inspect & Replace if Necessary	Minimum	
3	Freezer Door Gasket	X		
4	Front Bearing	X		
5	Draw Valve O-Ring	X		
6	Draw Valve Seal	X		
7	Pivot Pin O-Ring	X		
8	Prime Plug O-Ring	X		
9	Design Cap	X		
10	Inner Air Tube O-Ring	X		
11	Outer Air Tube O-Ring	X		
12	Air Orifice O-Ring	X		
13	White Bristle Brush, 3″ x 7″		Inspect & Replace if Necessary	Minimum
14	White Bristle Brush, 1″ x 2″		Inspect & Replace if Necessary	Minimum
15	Black Bristle Brush, 1″ x 2″		Inspect & Replace if Necessary	Minimum
16	Double-Ended Brush		Inspect & Replace if Necessary	Minimum

Refer to Parts List on page 30 when ordering above parts.





"Mr. Taylor" Tune-Up Kits are available from your Taylor Distributor. Keep your freezer in top condition with the above replacement parts in a Tune-Up Kit for your Model of freezer! Ask your Taylor Distributor about the Automatic 3-month Tune-Up Kit Mailing Program.

DESCRIPTION	PART NUMBER	QTY.	WARR. CLASS	REMARKS	PARTS UPDATE
BEARING-FRONT	050216	2	000		
BEARING-REAR SHELL *NICK.PLATE	031324	2	000		
+GUIDE-DRIP SEAL	028992	2	000		
+NUT-BRASS BEARING	028991	2	000		
+WASHER-BEARING LOCK	012864	2	000		
BEATER A.-2.8QT-HELICORE	X35466	2	103		
+BLADE-SCRAPER-PLASTIC 13-1/4L	035480	4	000		
BELT-AX40	023875	4	000		
BLOCK-TERMINAL 2P	039422	1	103		
BLOCK-TERMINAL 7 POLE GREEN	024156	1	103		
BLOCK-TERMINAL-PLUG 4P .2 SIP	040322-001	1	103		
BLOCK-TERMINAL-PLUG 6P .2 SIP	040322-002	2	103		
BLOCK-TERMINAL-PLUG 8P .2 SIP	040322-004	1	103		
BLOCK-TERMINAL-PLUG 10P .2 SIP	040322-005	1	103		
BRUSH-DOUBLE ENDED-PUMP&FEED T	013072	1	000		
BRUSH-DRAW VALVE 1”ODX2”X17”L	013073	1	000		
BRUSH-MIX PUMP BODY-3”X7”WHITE	023316	1	000		
BRUSH-REAR BRG 1IN.DX2IN.LGX14	013071	1	000		
CABLE-RIBBON-50C - 5”L	040040-010	1	103		
CABLE-RIBBON-14C - 45”L	040040-028	1	103		
CABLE-RIBBON-7C - 35”L	040040-029	1	103		
CABLE-RIBBON-20C - 14”L	040040-040	1	103		
CAP-DESIGN-1.010”ID-6 POINT	014218	3	000		
COMPRESSOR TL3G-R134A	047701-27	1	512	SHR	
+CAPACITOR-START-60UF-220/275V	047703	1	103	SHR	
+COVER-TERMINAL-COMPRESSOR	047739	1	103	SHR	
+KIT-MOUNTING-COMPRESSOR	047704	1	103	SHR	
+RELAY-START-COMPRESSOR-TL3G	047702-27	1	103	SHR	
COMPRESSOR-AHA-2490ZXD-AH556	047519-	1	512	TECUMSEH	
+CAPACITOR-START-135-155UF/330V	036048	1	103	208-230/60/1	
+RELAY-START-COMPRESSOR	036047	1	103	208-230/60/1	
+CAPACITOR-RUN- 35UF/440V	048132	1	103	208-230/60/1	
CONDENSER-AC-19X14X2.5 4 ROW	048623	1	103		
CONDENSER-STATIC	036052	1	103	DANFOSS SYSTEM	

DESCRIPTION	PART NUMBER	QTY.	WARR. CLASS	REMARKS	PARTS UPDATE
COUPLING-DRIVE 3/4 HEX X 1-7/8	012721	2	103		
COVER-HOPPER 14QT GRAY	041682-GRY	2	103		
DECAL-CLEAN INST.-HOPPER	019029	1	000		
DECAL-DEC-TWIN-SS	044214	1	000		
DECAL-POWER SWITCH	032484	1	000	SYMBOL J9109999/ PRIOR	148
DECAL-TROUBLESHOOTING	038374	1	000		
DISPLAY-LIQUID CRYSTAL	X38062-SER	1	103		
+LENS-DISPLAY	038221	1	000		
DIAGRAM-WIRING *337*	044553-	1	000		
DOOR A.-3 SPOUT	X51532-15	1	103		
DECAL-FREEZER DOOR	021521	1	000		
+HANDLE A.-DRAW-ADJ.	X33687	3	103		
HANDLE-ADJUSTABLE	028804	3	103		
O-RING-1/4 OD X .070W 50 DURO	015872	3	000		
SCREW-ADJUSTMENT	033662	3	000		
+NUT-5/16-24 18-8 SS JAM	029639-BLK	3	000		
+PLUG-PRIME	028805	2	103		
+O-RING-3/8 OD X .070W	016137	4	000		
+ROD A.-PIVOT	X20683	1	103		
+O-RING-5/16 OD X .070W	016272	1	000		
+VALVE A.-DRAW	X18303	3	103		
+O-RING-7/8 OD X .103W	014402	6	000		
DRYER-CAP. TUBE-HP62/R134A	047699	1	000	SHR	
DRYER-FILTER-HP62-3/8 X 1/4S	048901	1	000		
EYELET-RESET BUTTON	013739	2	000		
FUSE-7 AMP - IN LINE	047332	1	000		
+HOLDER-FUSE	045606	1	103		
GASKET-DOOR HT 4"-DOUBLE	048926	2	000		
GEAR A.*REDUCER-DUAL-OUTPUT	042934	1	212		
GUIDE A.-DRIP PAN *3337*	X41816	1	103		
HINGE A.-MOTOR	X25796	1	103		
HOOD *337*				HOOD IS NOT A SEPARATE SERVICE ITEM	
KIT A.-TUNE UP-3 SPOUT-NON HT	X49463-5	1	000		
BEARING-FRONT	050216	2	000		
CAP-DESIGN-1.010"ID-6 POINT	014218	3	000		

+ Available Separately

DESCRIPTION	PART NUMBER	QTY.	WARR. CLASS	REMARKS	PARTS UPDATE
GASKET-DOOR HT 4"-DOUBLE	048926	2	000		
O-RING .291ID X .080W	018550	6	000		
O-RING-.643 OD X .077W	018572	4	000		
O-RING-3/8 OD X .070W	016137	6	000		
O-RING-5/16 OD X .070W	016272	1	000		
O-RING-7/8 OD X .103W	014402	6	000		
SEAL-DRAW VALVE	034698	1	000		
SEAL-DRIVE SHAFT	032560	2	000		
TOOL- 0-RING REMOVAL	048260-WHT	1	000		
LABEL-DOOR CAUTION	032749	1	000		
LABEL-SW-POWER-OFF/ON-SYMBOLS	052632	1	000	J9110000/ UP	148
LABEL-WARN-COVER	051433	5	000	PANELS & CONTROL BOX	
LEG-4" W/O-RING	013458	4	103		
LOUVER-SIDE - LEFT	017471	1	103		
LUBRICANT-TAYLOR 4 OZ.	047518	1	000		
MAN-OPER 337	044869-M	1	000		
MOTOR-1.5 H.P.	021522-	1	212		
MOTOR-FAN 80 WATT 1550 RPM CW	051744-	1	103	6/01/00/ UP	
+FAN-5 BLADE 12" PUSH	047279	1	103		
+CAPACITOR-RUN- 4UF-440V	051785	1	103	6/01/00/ UP	
MOTOR-FAN - 120W	041401-	1	103	PRIOR TO 6/01/00	
+FAN-5 BLADE 12" PUSH	047279	1	103		
+CAPACITOR-RUN 4UF/370V	019624	1	103	PRIOR TO 6/01/00	
NUT-STUD *460-664-754-56*LONG	034382	2	103		
NUT-STUD *460-664-754-56*SHORT	034383	2	103		
ORIFICE	022465-100	2	103		
+O-RING-3/8 OD X .070W	016137	2	000		
PAIL-MIX 6 QT	023348	1	000		
PAN-DRIP 17-1/4"LONG	027504	1	103		
PAN A.-HINGED	X41844	1	103		
PANEL A.-FRONT *337*	X44247	1	103		
PANEL A.-UPPER SIDE RIGHT	X48596	1	103		
PANEL-REAR	044287	1	103		
PANEL-SIDE-RIGHT & LEFT	048487	1	103		
PLATE A.-DEC-337	X44276	1	103		

+ Available Separately

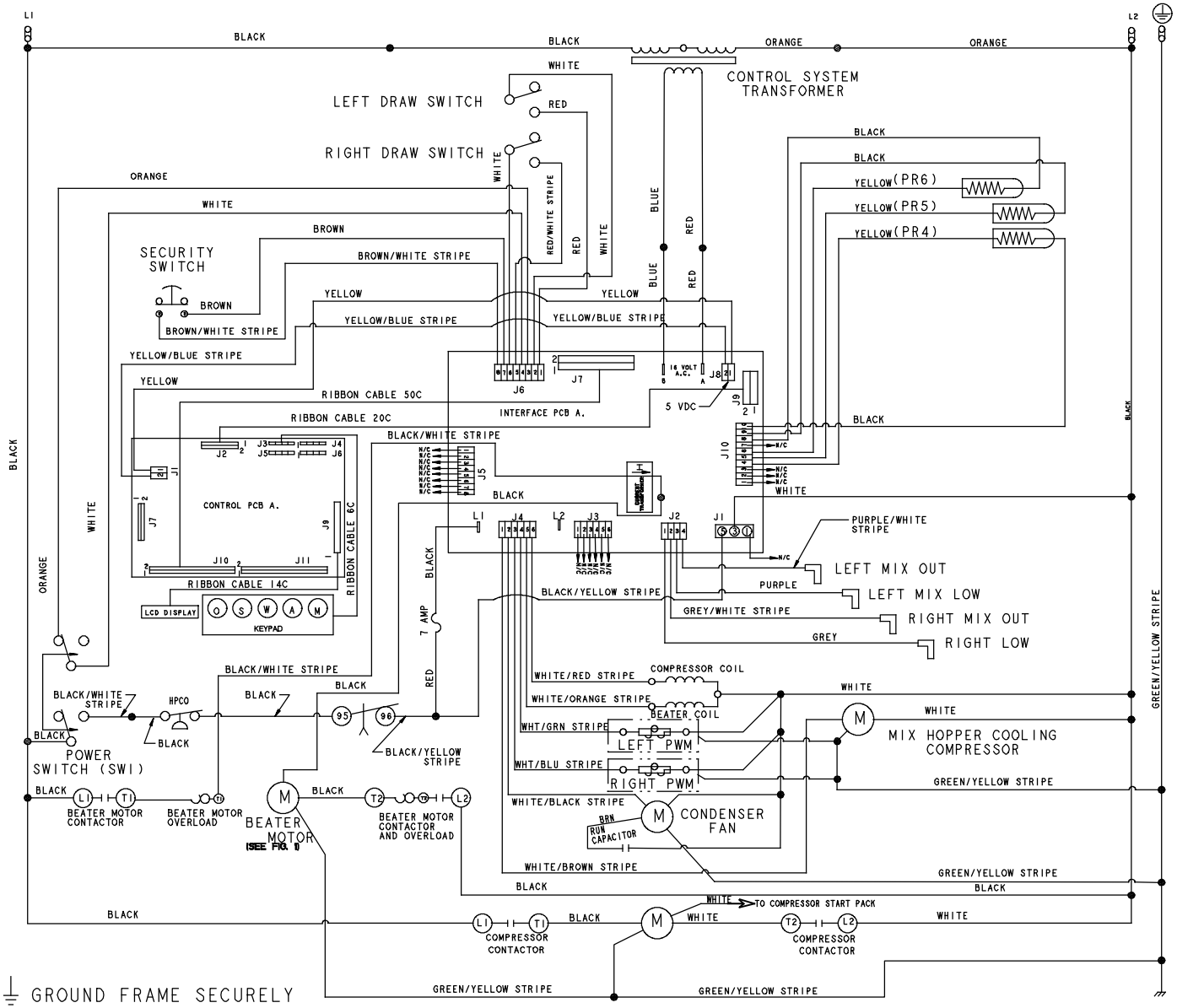
DESCRIPTION	PART NUMBER	QTY.	WARR. CLASS	REMARKS	PARTS UPDATE
PROBE A.-MIX *SQUARE*	X30922	2	103		
PROBE A.-MIX OUT	X41348	2	103		
PROBE A.-THERMISTOR - HOPPER	X45047-SER	1	103		
PROBE-THERMISTOR-HOPPER-2% TOL	039470-BLK	1	103		
PROBE A.-THERMISTOR - BARREL	X45046-SER	1	103		
PROBE-THERMISTOR-BARREL-2% TOL	038061-BLK	1	103		
PULLEY-2AK20 X 5/8 BORE	034238	1	103	BEATER MOTOR	
PULLEY-2AK74-5/8 BORE	027822	1	103	GEAR	
PCB A.-CONTROL *UVC2*	X53487-SER	1	212	J9071700/UP (REPLACES X45313-SER)	144
Includes:					
CHIP-SOFTWARE	X40785	1	103	J9071700/UP	144
PCB A.-UVC2	X51169-SER	1	212	J9071700/UP	144
CHIP-SOFTWARE UVC2 DISPLAY	X40872	1	103		
CHIP-SOFTWARE UVC2 CHIP-SEL	X40873	1	103		
CHIP-SOFTWARE UVC2 U10 ENGLISH	X40875	1	103		
CHIP-SOFTWARE UVC2 U11	X40876	1	103		
PCB A.-CONTROL (OLD)	X45313-SER	1	212	PRIOR TO J9071700	144
Includes:					
CHIP-SOFTWARE	X40836	1	103	PRIOR TO J9071700	144
PCB A.-UNIVERSAL CONTROL	X44863-SER	1	212	PRIOR TO J9071700	144
PCB A.-INTERFACE	X44295-SER	1	212		
RELAY-3 POLE-20A-208/240 50/60	012725-33	1	103		
SANITIZER KAY-5 125 PACKETS	041082	1	000		
SHAFT-BEATER	033235	2	103		
+SEAL-DRIVE SHAFT	032560	2	000		
SHELL A.-INSULATED *339* (NEW)	X53251	1	512	J9070000/UP	145
SHELL A.-INSULATED *339*	X45001	1	512	PRIOR TO J9070000	145
+STUD-NOSE CONE	022822	4	103		
SHIELD-SPLASH	022765	1	103		
SKIRT-AIR FLOW	048489	1	103	DEFLECTOR	
STARTER-1 PHASE-4.5 TO 7 A	041950-	1	103		
SWITCH A.-DRAW *SELF CLOSING*	X38547	1	103		
ARM-SWITCH-DRAW-LEFT	038649	1	103		
ARM-SWITCH-DRAW-RIGHT	038650	1	103		
BRACKET A.-SPRING RETURN	X38257	1	103		

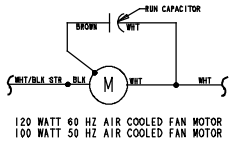
+ Available Separately

DESCRIPTION	PART NUMBER	QTY.	WARR. CLASS	REMARKS	PARTS UPDATE
BRACKET A.-SWITCH *338-39-754	X38252	1	103		
E-RING 1/4	032190	4	000		
PIN-PIVOT-DRAW SWITCH	038484	1	103		
ROD-SPRING RETAINER	038254	1	103		
SCREW-8-32X3/8 HEX HD TYPE 23	039267	2	000		
SPRING-EXTENSION.375X.045X1.00	038922	2	103		
SPRING-RETURN-LEFT-TWIN TWIST	038923	1	103		
SPRING-RETURN-RIGHT-TWIN TWIST	038924	1	103		
SWITCH A.-DRAW-TWIN TWIST	X39269	1	103		
BRACKET-DRAW SWITCH-TWIN TWIST	039264	1	103		
SCREW-4-40 X1/2”TAPTITE PAN HD	042604	4	000		
SWITCH-LEVER-SPDT-11A-125-277V	039252	2	103		
SWITCH-MEMBRANE - 5 POSITION - 8”L	044520	1	103		
SWITCH-PRESSURE 440 PSI-SOLDER	048230	1	103		
SWITCH-PUSHBUTTON/NEON DISPLAY	030629-	1	103		
SWITCH-TOGGLE-DPDT-ON NONE ON	024295	1	103	POWER	
TRANS-CONT. 40VA	045754	1	103		
TRAY-DRIP - 16-7/8L X 5-1/8	020157	1	103		
TRIM-FRONT	044286	1	103		
TRIM-REAR CORNER L.	044280	1	103		
TRIM-REAR CORNER R.	044281	1	103		
TUBE A.-FEED-INNER	X32824-2	2	103		
+O-RING-INNER FEED TUBE	018550	6	000		
TUBE A.-FEED-OUTER	X34641	2	103		
+O-RING-OUTER FEED TUBE	018572	4	000		
VALVE-ACCESS 1/4 X 3/8 SOLDER	029406	1	103	MAIN L/S	
VALVE-ACCESS 1/4FL X 1/4SOLDER	044404	1	103	EPR	
VALVE-ACCESS-1/4 MFLX1/4 S-90	047016	2	103	MAIN H/S & AUX L/S	
VALVE-EPR 1/4S	022665	1	103		
VALVE-EXP-PULSE 3/8S 240VAC	044335-27	2	103		
VIDEO-TRAIN FILM-SS 337	047572-	1	000		
WASHER-PLASTIC PIVOT	013808	4	000		

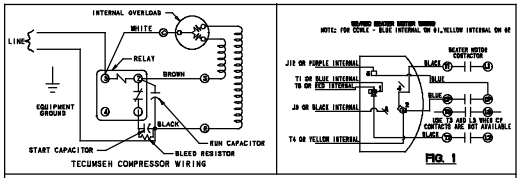
+ Available Separately

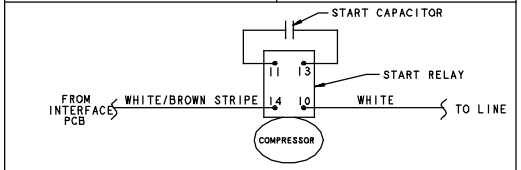
DESCRIPTION	PART NUMBER	QTY.	WARR. CLASS	REMARKS	PARTS UPDATE
WATER COOLED					
CONDENSER-W/C	049309	1	103		
MOTOR-FAN -25W 230VOLT	015184-	1	103		
+FAN-5 BLADE 10” PUSH	013043	1	103		
SWITCH-PRESSURE 350PSI-SOLDER	048231	1	103		
VALVE-WATER 3/8 REG/HEAD PRESSURE	046686	1	013		
50Hz					
BELT-AX41	023876	2	000		
CAPACITOR-RUN-35UF/370VOLT	029439	1	103	220-240/50/1 COMPRESSOR	
CAPACITOR-START 135/155UF/330VOLT	036048	1	103	220-240/50/1 COMPRESSOR	
RELAY-START COMPRESSOR	036047	1	103	220-240/50/1 COMPRESSOR	
MOTOR-FAN 100W 220-240VOLT	047178-34	1	103		
+CAPACITOR-RUN- 4UF-370V	019624	1	103		
PULLEY 2AK27 X .625	011545	1	103	BEATER MOTOR	





120 WATT 60 HZ AIR COOLED FAN MOTOR
100 WATT 50 HZ AIR COOLED FAN MOTOR





DANFOSS COMPRESSOR WIRING (MODEL TL3G)

SYMBOLS

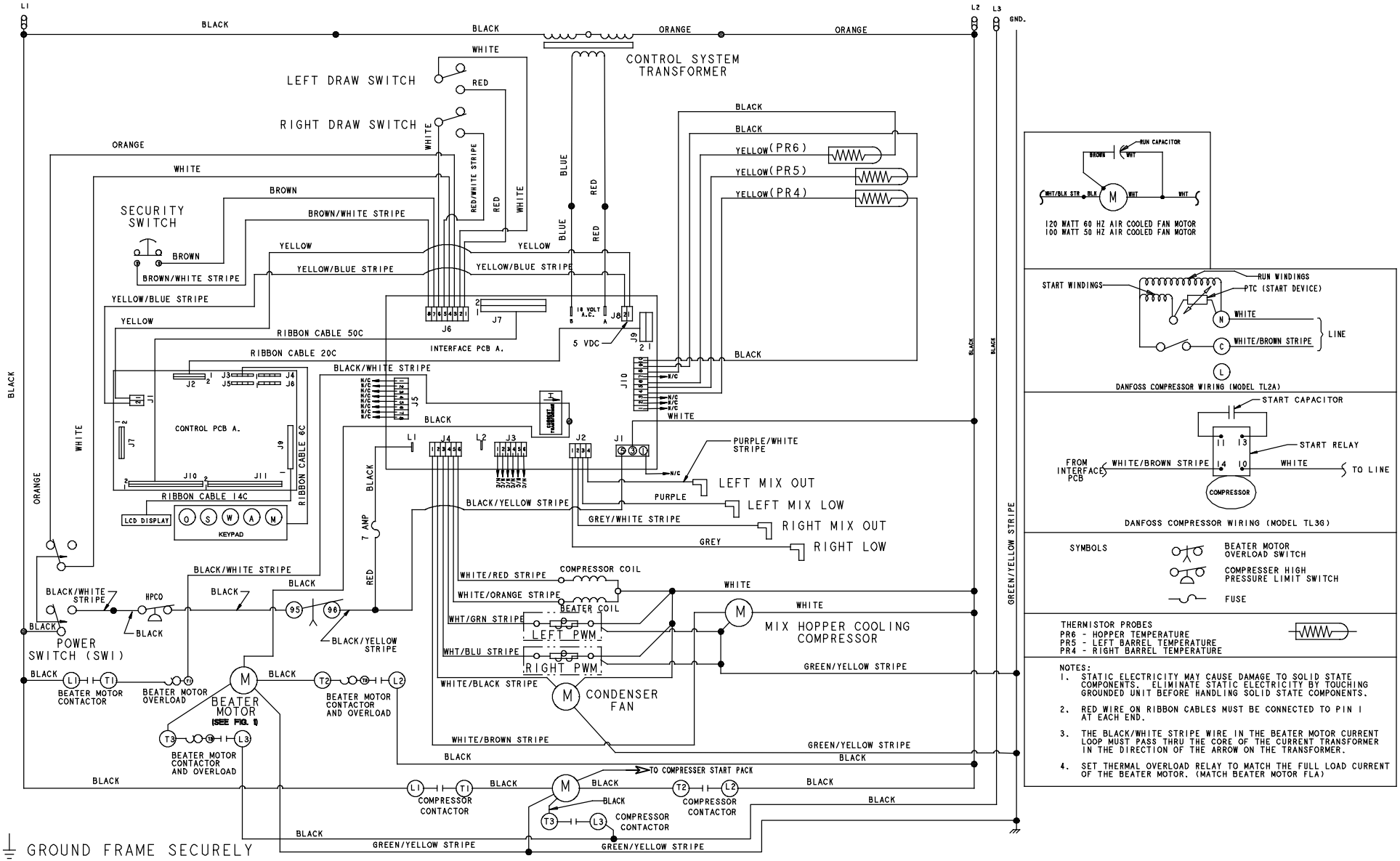
- BEATER MOTOR OVERLOAD SWITCH
- COMPRESSOR HIGH PRESSURE LIMIT SWITCH
- FUSE

THERMISTOR PROBES
PR6 - HOPPER TEMPERATURE
PR5 - LEFT BARREL TEMPERATURE
PR4 - RIGHT BARREL TEMPERATURE

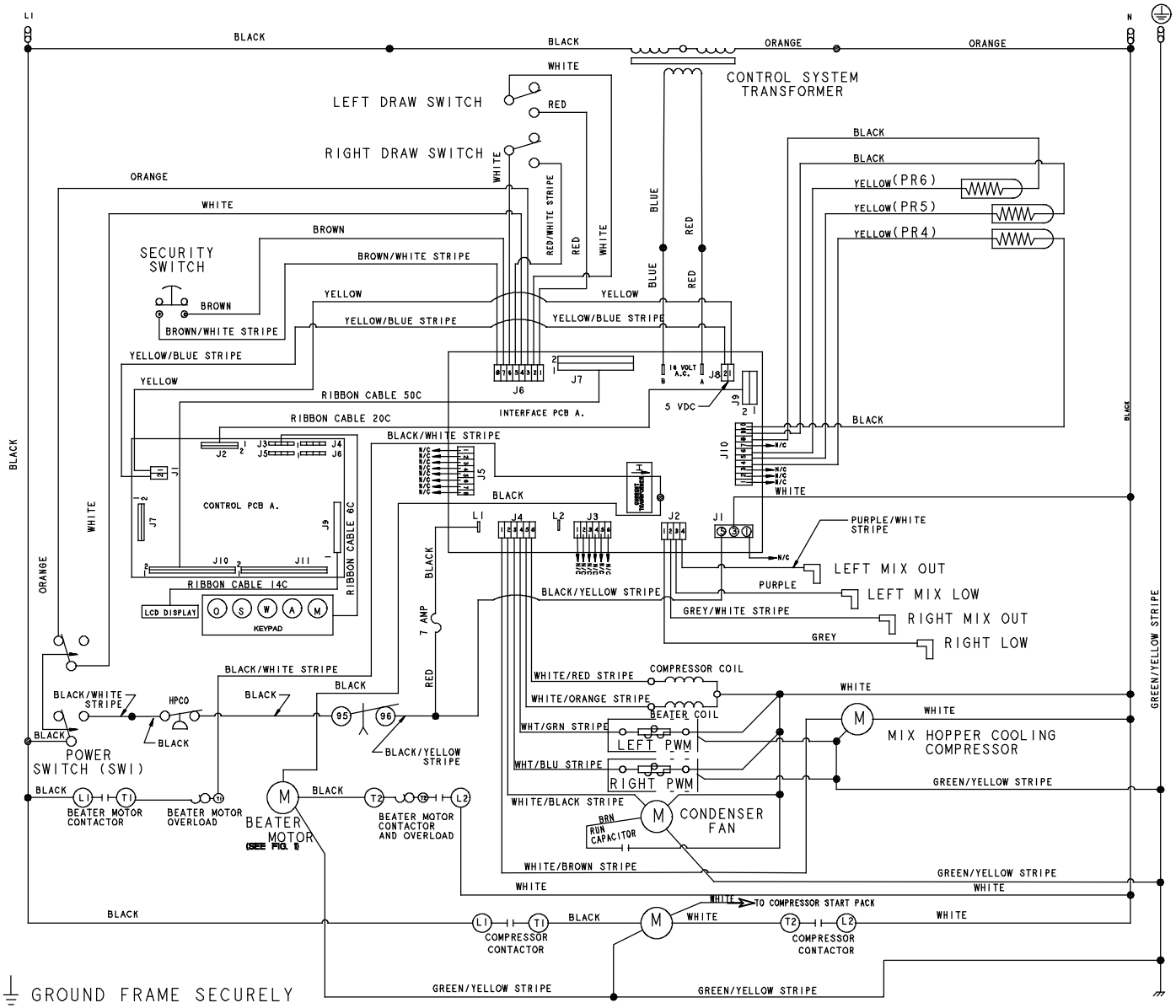
NOTES:

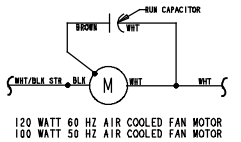
1. STATIC ELECTRICITY MAY CAUSE DAMAGE TO SOLID STATE COMPONENTS. ELIMINATE STATIC ELECTRICITY BY TOUCHING GROUNDED UNIT BEFORE HANDLING SOLID STATE COMPONENTS.
2. RED WIRE ON RIBBON CABLES MUST BE CONNECTED TO PIN 1 AT EACH END.
3. THE BLACK/WHITE STRIPE WIRE IN THE BEATER MOTOR CURRENT LOOP MUST PASS THRU THE CORE OF THE CURRENT TRANSFORMER IN THE DIRECTION OF THE ARROW ON THE TRANSFORMER.
4. SET THERMAL OVERLOAD RELAY TO MATCH THE FULL LOAD CURRENT OF THE BEATER MOTOR. (MATCH BEATER MOTOR FLA)

Model 337
044553-27G
7/16/12

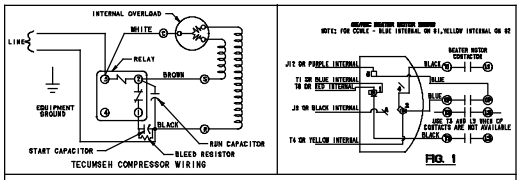


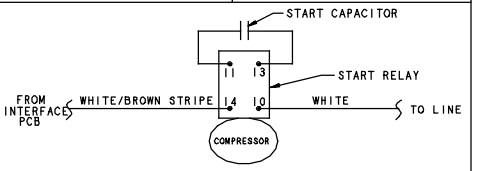
Model 337
044553-33G
7/16/12





120 WATT 60 HZ AIR COOLED FAN MOTOR
100 WATT 50 HZ AIR COOLED FAN MOTOR





DANFOSS COMPRESSOR WIRING (MODEL TL3G)

SYMBOLS

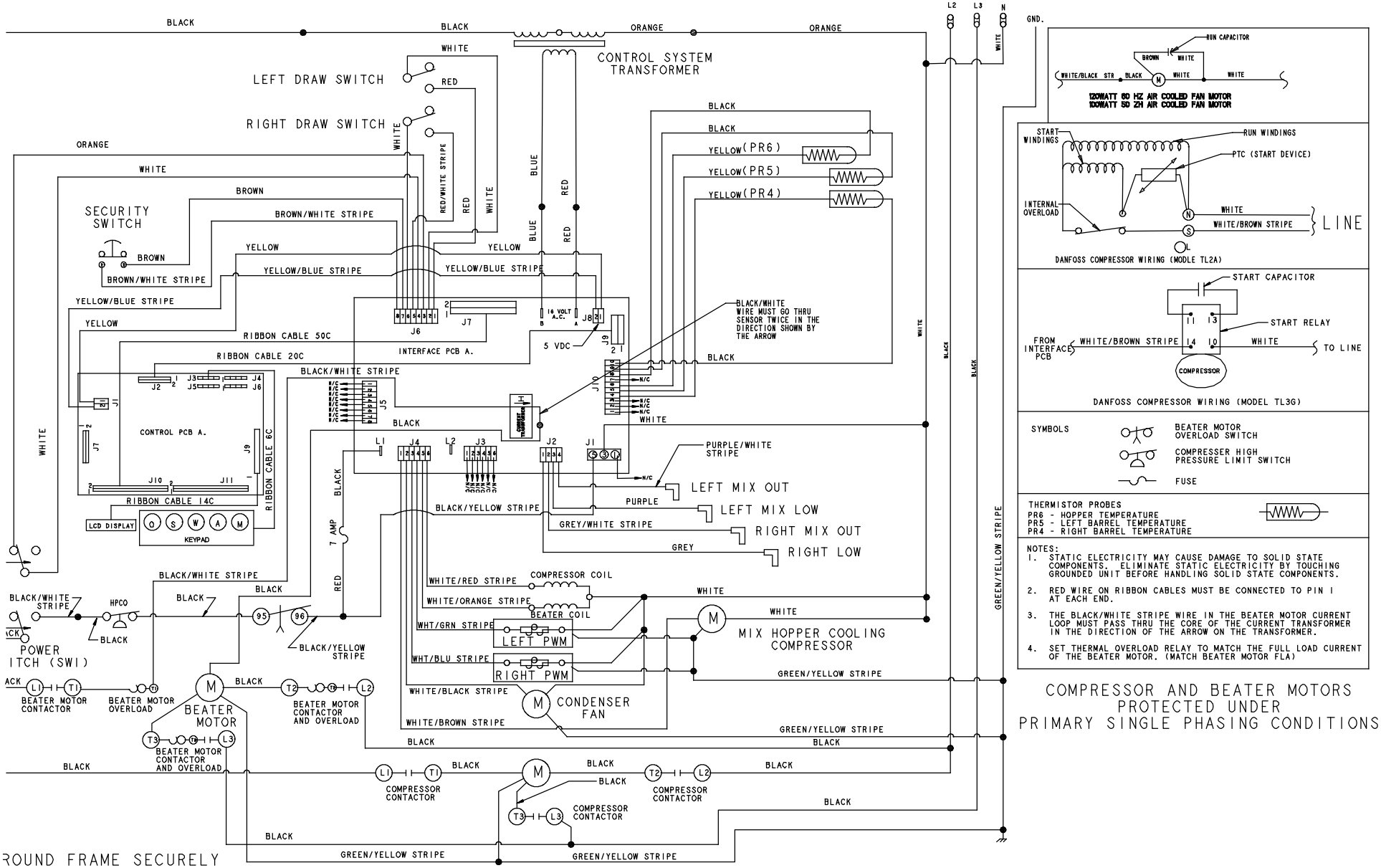
- BEATER MOTOR OVERLOAD SWITCH
- COMPRESSOR HIGH PRESSURE LIMIT SWITCH
- FUSE

THERMISTOR PROBES
PR6 - HOPPER TEMPERATURE
PR5 - LEFT BARREL TEMPERATURE
PR4 - RIGHT BARREL TEMPERATURE

NOTES:

1. STATIC ELECTRICITY MAY CAUSE DAMAGE TO SOLID STATE COMPONENTS. ELIMINATE STATIC ELECTRICITY BY TOUCHING GROUNDED UNIT BEFORE HANDLING SOLID STATE COMPONENTS.
2. RED WIRE ON RIBBON CABLES MUST BE CONNECTED TO PIN 1 AT EACH END.
3. THE BLACK/WHITE STRIPE WIRE IN THE BEATER MOTOR CURRENT LOOP MUST PASS THRU THE CORE OF THE CURRENT TRANSFORMER IN THE DIRECTION OF THE ARROW ON THE TRANSFORMER.
4. SET THERMAL OVERLOAD RELAY TO MATCH THE FULL LOAD CURRENT OF THE BEATER MOTOR. (MATCH BEATER MOTOR FLA)

Model 337
044553-40
7/16/12


L2
L3
N
GND.
BLACK
ORANGE
CONTROL SYSTEM TRANSFORMER
LEFT DRAW SWITCH
RIGHT DRAW SWITCH
WHITE
RED
RED/WHITE STRIPE
BLUE
SECURITY SWITCH
BROWN
BROWN/WHITE STRIPE
YELLOW
YELLOW/BLUE STRIPE
YELLOW(PR6)
YELLOW(PR5)
YELLOW(PR4)
BLACK/WHITE WIRE MUST GO THRU SENSOR TWICE IN THE DIRECTION SHOWN BY THE ARROW
16 VOLT A.C.
5 VDC
J6
J7
J8
J9
J10
INTERFACE PCB A.
RIBBON CABLE 50C
RIBBON CABLE 20C
RIBBON CABLE 6C
RIBBON CABLE 14C
CONTROL PCB A.
LCD DISPLAY
KEYPAD
BLACK/WHITE STRIPE
PURPLE/WHITE STRIPE
LEFT MIX OUT
PURPLE
LEFT MIX LOW
BLACK/YELLOW STRIPE
GREY/WHITE STRIPE
RIGHT MIX OUT
GREY
RIGHT LOW
7 AMP
HPCO
POWER SWITCH (SWI)
95
96
WHITE/RED STRIPE
COMPRESSOR COIL
WHITE/ORANGE STRIPE
BEATER COIL
WHT/GRN STRIPE
LEFT PWM
WHT/BLU STRIPE
RIGHT PWM
MIX HOPPER COOLING COMPRESSOR
GREEN/YELLOW STRIPE
WHITE/BLACK STRIPE
CONDENSER FAN
WHITE/BROWN STRIPE
BEATER MOTOR CONTACTOR
BEATER MOTOR OVERLOAD
BEATER MOTOR
BEATER MOTOR CONTACTOR AND OVERLOAD
COMPRESSOR CONTACTOR
ROUND FRAME SECURELY
Model 337
044553-62G
7/16/12
RUN CAPACITOR
120WATT 60 HZ AIR COOLED FAN MOTOR
100WATT 50 ZH AIR COOLED FAN MOTOR
START WINDINGS
RUN WINDINGS
PTC (START DEVICE)
INTERNAL OVERLOAD
LINE
DANFOSS COMPRESSOR WIRING (MODLE TL2A)
START CAPACITOR
START RELAY
FROM INTERFACE PCB
TO LINE
COMPRESSOR
DANFOSS COMPRESSOR WIRING (MODEL TL3G)
SYMBOLS
BEATER MOTOR OVERLOAD SWITCH
COMPRESSER HIGH PRESSURE LIMIT SWITCH
FUSE
THERMISTOR PROBES
PR6 - HOPPER TEMPERATURE
PR5 - LEFT BARREL TEMPERATURE
PR4 - RIGHT BARREL TEMPERATURE
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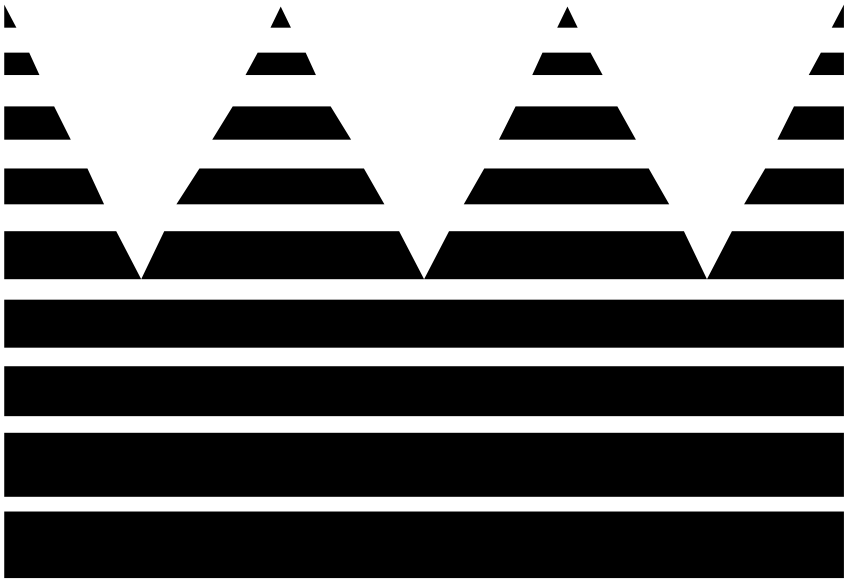
4. SET THERMAL OVERLOAD RELAY TO MATCH THE FULL LOAD CURRENT OF THE BEATER MOTOR. (MATCH BEATER MOTOR FLA)
COMPRESSOR AND BEATER MOTORS PROTECTED UNDER PRIMARY SINGLE PHASING CONDITIONS



044869-M